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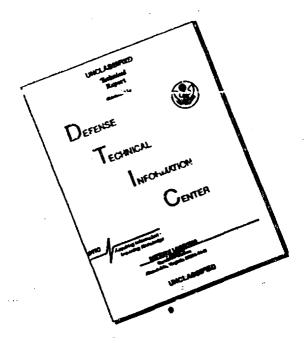
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### **TECHNOLOGY INSERTION-ENGINEERING SERVICES** PROCESS CHARACTERIZATION TASK ORDER NO. 1 (BLOCK II)

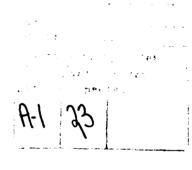
### **DATABASE DOCUMENTATION BOOK**

OC-ALC

MATPCA

**CONTRACT SUMMARY REPORT 11 SEPTEMBER 1989** 

CONTRACT NO. F33600-88-D-0567 **CDRL SEQUENCE NO. B008** 





MCDONNELL DOUGLAS

McDonnell Douglas Missile Systems Company St. Louis, Missouri 63166-0516 (314) 232-0232

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### 1.0 IDENTIFICATION OF RCC

MATPCA is separated into two sections, each having its own workload and personnel. The two sections are physically separated by an eight foot isle which runs between them. The two sections share storage cabinets and some test equipment, but otherwise exist as separate entities, each having its own supervisor. Workloads appear to be divided equitably based on existing staffing.

The first section's workload consists mostly of ignition exciters, temp. probes, electrically actuated valves, and associated electrical accessories. The work area is somewhat crowded with test equipment and work benches, much of which is not being utilized due to the present workload levels. The existing facilities would be capable of processing a much greater workload given the needed staffing. This section contains 6,250 square feet of floor space.

The second section's workload is mostly made up of temperature amplifiers, servo-motors, and power supllies. Again, the area contains several benches and and testing equipment which is not being utilized at their full potential given the present workload. The section contains 2,875 square feet of floor space.

Note that MISTR items are normally delivered to an outside storage area in building 3123. Technicians normally are sent to this area once a week to uncrate accessories and load them onto a transport trailer.

### 2.0 GENERAL INFORMATION

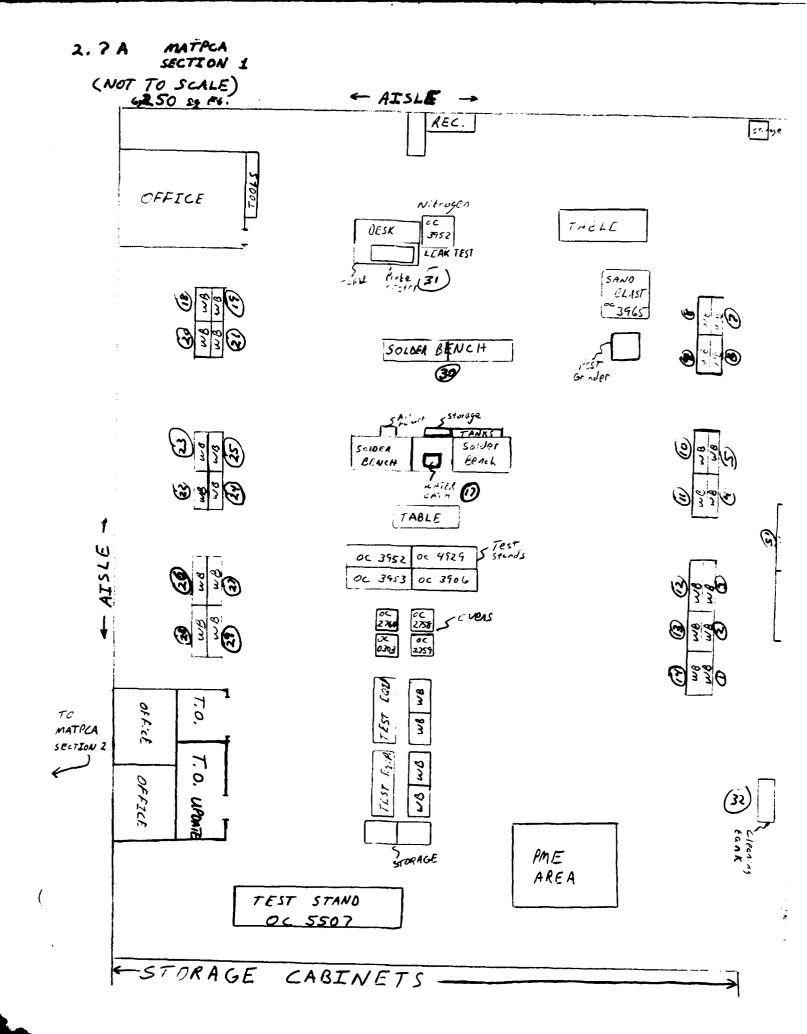
MATPCA is an electrical accessories repair unit within the Accessories Division Production Branch at OC-ALC. This RCC is located in building 3001.

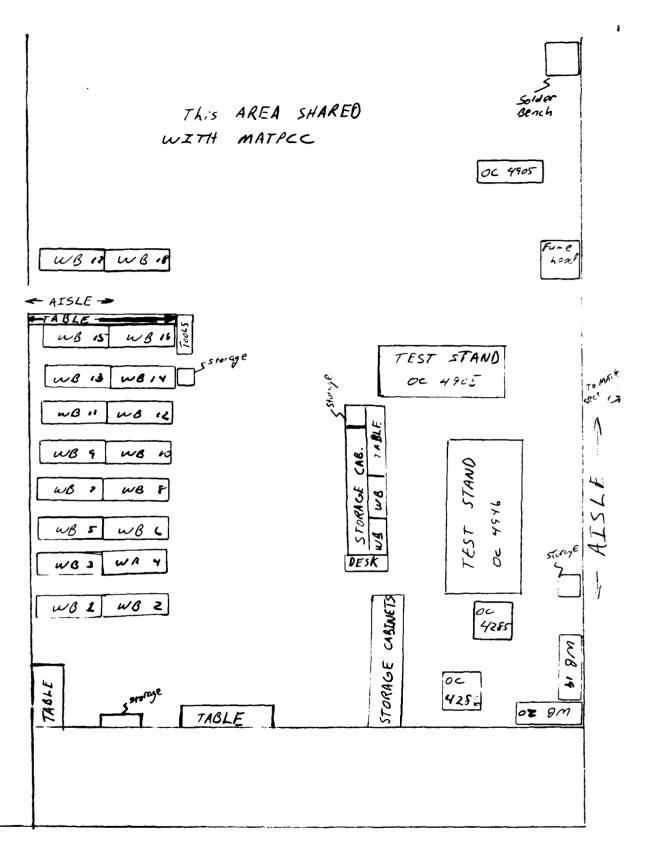
The primary responsibility of MATPCA is to overhaul, repair, and bench test motors, exciters, power supplies, servo-motors, and a variety of aircraft and engine electrical accessories. The primary workload in this RCC consists of MISTR and PDM items, with the PDM accessories being worked mainly as support for the engine overhaul unit at OC-ALC.

The workload of MATPCA has been relatively stable for the last several years, but it should be mentioned that production levels for recent months has been lower due to decreasing demand for certain aircraft parts. MATPCA has historically worked electrical accessory parts for the A-7, F-4, and B-52 aircraft. As these aircraft are phased out of the active Air Force inventory, demand for overhaul and repair work has decreased. We may expect to see production levels increase as new electrical accessories from aircraft such as the F-16 and B-1 enter the depot system. It must be emphasized that MATPCA is in a transition period between the old and new aircraft technologies, and that a definitive workload analysis would need to account for the changing patterns of processed parts.

### 2.1 FACILITY LAYOUT DRAWING

The existing facility layout drawings are not representative of the present conditions. There have been changes to the shop floor as well as a restructuring of the MATPCA RCC. The attached layouts are representative of the present conditions.





- AISLE ->

2.7B MATPCA SECTION 2 (NOT TO SCALE)

2, 875 sg ft.

### 2.2 EQUIPMENT

Equipment presently used in the MATPCA RCC consists of a variety of electrical test stands, common electrical testing equipment such as oscilloscope, ohmmeters, meggers, etc., and both common and specialized hand tools.

The test stands used in this RCC range from four to thirty years old, with much of the equipment being at least twenty years old. It is somewhat surprising that newer equipment purchased in the last five years to support repair and testing of B-1 and F-16 electrical accessories shows a much higher rate of downtime and repair requests than does the older equipment.

A detailed listing of the equipment used in MATPCA is included in the equipment profile, which is enclosed in this report.

### 2.3 WORKFORCE

MATPCA has a relatively stable workforce with little variance. Workloads are well defined and personnel appear knowledgeable about their tasks. The workforce is comprised of two supervisors, 32 journeyman technicians, a sandblast technician, and a painter. The following is a breakdown of the manpower in the MATPCA RCC.

SKILL CODE	SKILL LEVEL	QUANTITY	EXPERIENCE
AY	<b>W</b> G-10	5	12
	WG-9	б	8
BY	WG-10	10	7
	₩G-9	10	4
	WG-7	2	6
ВЭ	<b>W</b> G-7	1	2

Experience is given as average years at that grade.

Note that MATPCA is supported by two backshops, MATPCM machine shop and MATPIW welding shop.

### 2.4 REPAIR PROCESS TECHNOLOGIES

The repair process technology in MATPCA consists of testing and repair of aircraft and aircraft engine electrical accessories.

Accessories are tested for function and specification requirements, and overhaul is performed as required. Modifications are made to existing items as required be tech order changes and to meet the present configuration required for targeted aircraft.

When applicable, repairs are made to internal components of the worked accessories, as well testing,

replacement of defective parts, and inspection of problems requiring backshop support.

### 2.5 WORKLOAD VOLUME AND MIX

The workload within MATPCA consists of both MISTR and PDM. Electrical accessories sent to the engine overhaul facility at OC-ALC is a PDM workload. All other items tested and/or overhauled are MISTR designated.

Workloads are variable and depend on Air Force inventory needs. For more information see the enclosed workload profile.

### 2.6 MATERIAL HANDLING

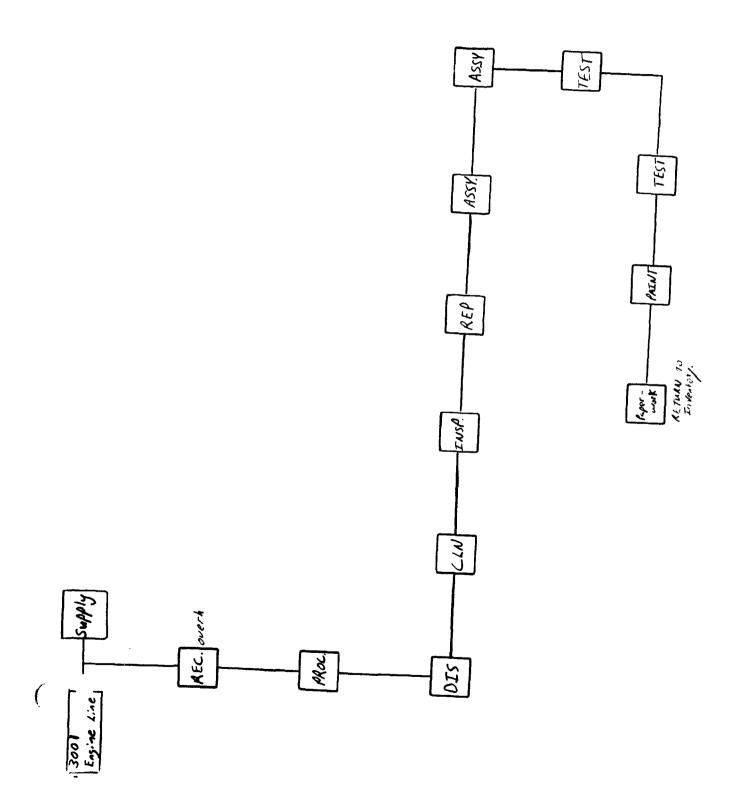
Material handling in MATPCA is mostly by hand. Material is initially received in building 3123. Technicians are sent to this area to uncrate received items and place them on a specially suspended trailer. A tug driver is then called to move the items to Bld. 3001 where they are placed in storage cabinets. This procedure is normally performed once a week and requires approximately four hours of the skilled technician's time.

### 2.7 STORAGE

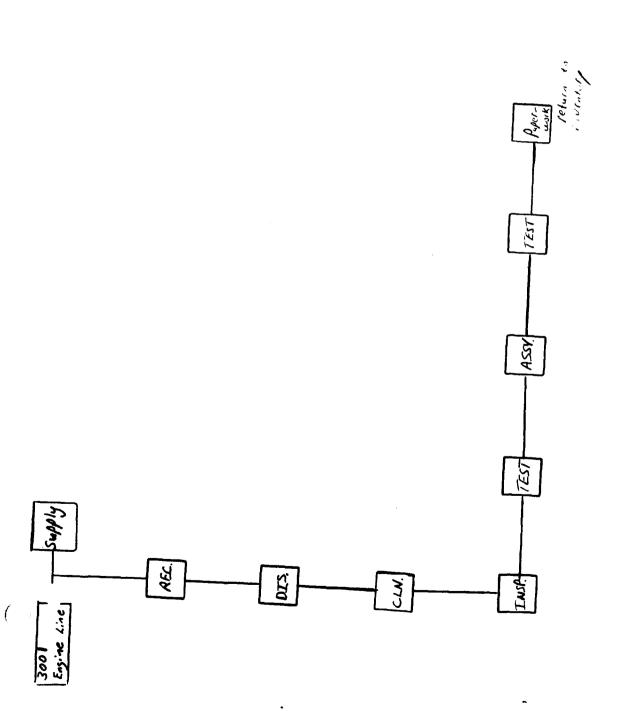
Storage in the MATPCA area consists of 76 cabinets that are 6x3x2 feet in size. These cabinets are located throughout the MATPCA shop area as shown on the facility layout drawing enclosed.

### 2.8 PROCESS FLOW DIAGRAMS

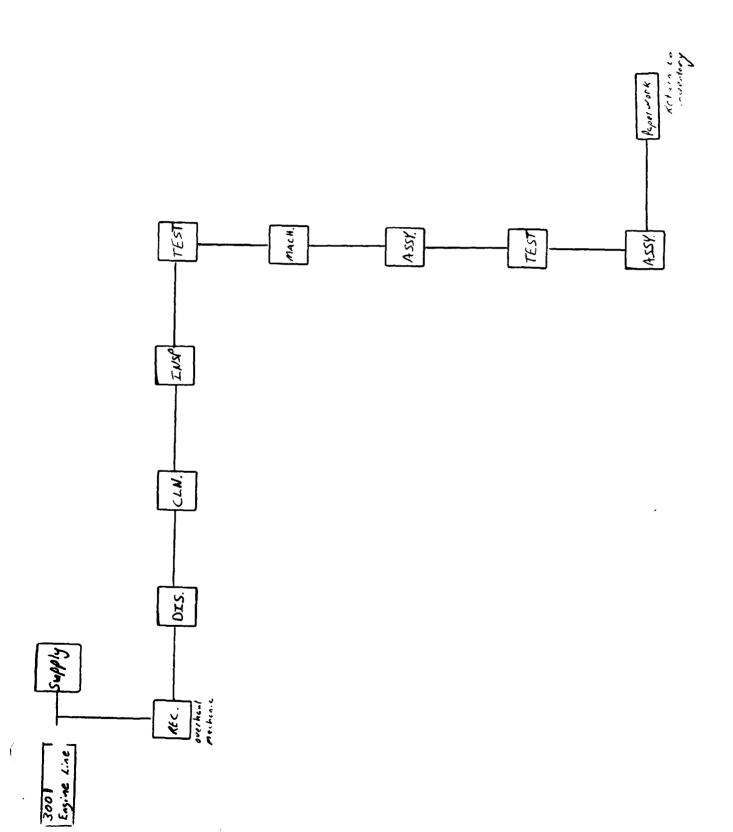
The following process flow diagrams are representative of the operations required to test and/or overhaul the various items worked by the MATPCA Accessories RCC. The items have been divided into family groups (i.e., like items in regard to designation and function). Operations shown often represent a logical combination of similar and related tasks. For more detailed analysis of the processes studied, please refer to the appropriate operation profile packet (enclosed).



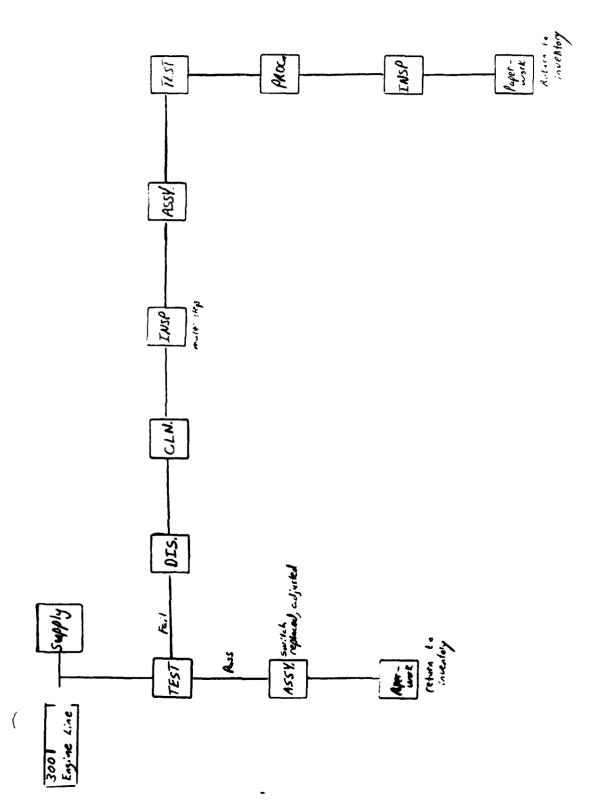
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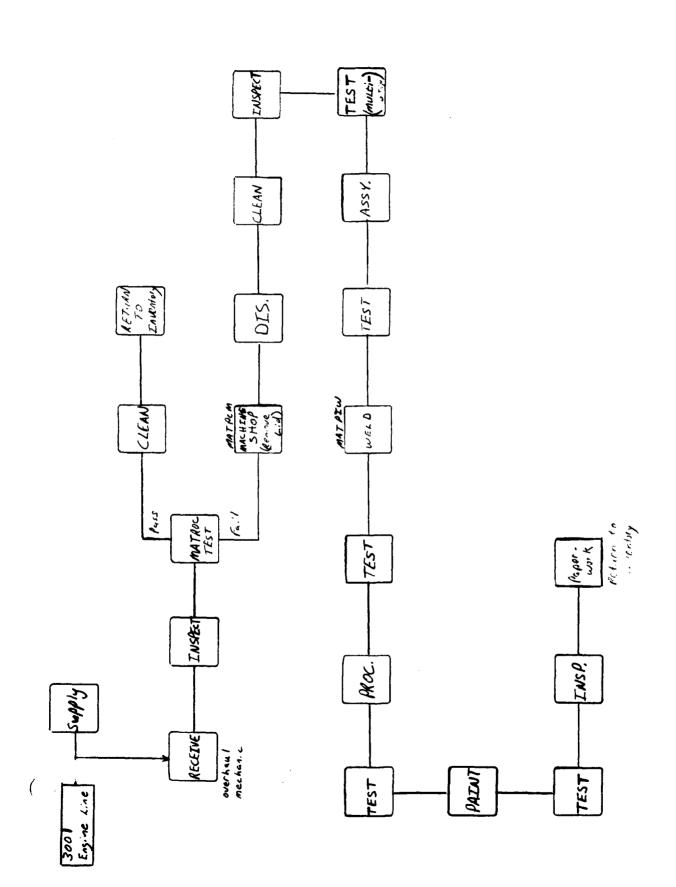


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### 3.0 <u>80/20 WORKLOAD ANALYSIS</u>

An 80/20 analysis was previously performed for MATPCA using information obtained from AFLC "TOP DOLLAR ITEM" lists. These lists assumedly weighted the items on the basis of earned hours reported for each control number worked. In the case of MATPCA, this list proved dated, with several of the PCNs having been reassigned to other RCCs. An updated list was formed by reviewing the recent history of items processed, and replacing those PCNs that were no longer relevant with presently processed items of equal or greater earned hours. The following is the updated list of those part control numbers identified as representing 80% of MATPCA's present workload:

CONTROL NUMBER	WCD NAME
35023A	CAEY10
98093A	CAEC11
34253A	CAAC24
37719A	CAA001
38718A	CAEM02
38645A	CAEM08
30241A	CAEB05
34044A	CAEC04
49711A	CAEC07
*35111A	CAEZ08
34128A	CAEY08
98001A	CAEC07

<sup>1</sup> 38694A	CAEM09
50217A	CAEA01
50078A	CAEZ05
38669A	САЕМОЗ
35510A	CAEY12
31151A	CA2222
30056A	CAEZ03
*34252A	CAAC02
*34551A	CAEZ04
*35113A	CAEZ02
38643A	CAEM04
49315A	CAEY09
61234A	CAEC05
*35033A	CAEY11
*97133A	CAEB08
50297A	CAEM22

\* These are the PCNs that were placed on this list in order to update it to present conditions observed in MATPCA.

### 3.1 <u>VALIDATION</u>

Validation of the 80/20 list was performed as described in the preceding section. The updated list is believed to be representative of the MATPCA workload.

### 4.0 DATA COLLECTION

Of the data profile sheets collected, the following were found to be applicable to the MATPCA RCC:

- Operation Profile
- Manpower Profile
- Equipment Profile

Disassembly/Assembly Profiles and Parallel Process
Profiles were not applicable to this RCC due to the nature
of the work performed. All information represented on the
operation profile sheets was developed primarily from
information provided by the interviewed technicians.
Manpower availability and equipment profile information was
provided by shop supervisors.

### 4.1 DATA COLLECTION PROCESS

Each control number identified on the 80/20 list had an operation profile developed for it. The applicable shop foreman identified the technician most familiar with the item being studied, and an interview was performed to determine the relevant operations and their associated time requirements.

Please note that while a specific WCD (work control document) is the primary paperwork associated with any particular item's control number, this WCD can not be

regarded as an accurate description of the actual operations required for testing and overhaul of that item. The WCD should instead be considered as only a tracking device for the existing PAC certification program.

# WORKLOAD PF FILE

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OPERATION'S COFILE

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	020	ODDUV	DIS ASSEM	560	590	ODDO	PAINT
	025		REPAIR		595	DODUT	
030	030	● OD □ ▽	CLEAN	570	610		TEST
	0 40	ODDO	INSP	670	670	ODDO	PN
060	060	ODDU	TEST	650	680		SAF WIRE
	100	ODDO	TEST	660	690		PH
070	160	OODUV	TEST		700		
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## 5.1 PROFILE DATA FILES

The profile data files for RCC MATPCA were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

# 5.2 MODEL INPUT FILES

The model input files for RCC MATPCA were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

# 6.0 VALIDATION OF INPUT DATA

All profile data was validated in accordance with paragraph 7.2 and 7.3 of the Simulation Model Definition Document (SMDD). The profile data files included in this document were validated and accurately represent MATPCA.

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# 7.0 COMPUTER SIMULATION ANALYSIS OF RCC

The computer simulation analysis for RCC MATPCA was previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

# 8.0 VALIDATION OF SIMULATION ANALYSIS

The validation of simulation analysis for RCC MATPCA was previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

# 9.0 BRAINSTORMING

The minutes for RCC MATPCA brainstorming were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

## 10.0 EXPERIMENTATION

Experimentation is the process by which the factors and levels developed in brainstorming are tested for interaction and effect. The factors and levels identified are fitted into a Taguchi orthogonal array, which then defines the experimental design. Changes in quality characteristics, such as throughput and/or simulated process flow times, are then analyzed as experimental results. Taguchi methodology is used in performing this analysis.

It is important to understand the process by which experimentation is developed if useful information is to be obtained. For this reason, the following discussion will attempt to define certain terms, approaches, and desired results in regard to the experimentation process.

It is often the case that technical information needed for making a decision regarding a process or product is unknown. Since this information is in most cases needed as quickly and inexpensively as possible, the Taguchi method of using fractional factorials in the form of orthogonal arrays is considered a method of choice.

Two terms require definition due to their fundamental importance in developing and interpreting the orthogonal array. A <u>factor</u> is a parameter purposefully altered so that resulting changes in the output variable may be observed. <u>Levels</u> are the different settings for each factor in a designed experiment.

The advantages of using orthogonal arrays are: The main effects of factors under test are balanced and separable, the number of experiments required is greatly reduced, and the ease with which test planning and data analysis may be performed. This allows the arrays to be applied to a broad spectrum of problem identification and analysis.

Test matrices developed by Dr. Taguchi, et al, are applied to the orthogonal array for which it is applicable. Mathematical analysis of the quality characteristic chosen is then accomplished using the test matrices to find the best combination of factors and levels. The convention for identification of test matrices is as follows:

Where N = number of experimental runs.

K = maximum number of factors that may be included in test.

Two factors are said to interact (in their effect on the output variable) if the effect of one factor is different at the different levels of another factor. If two factors physically interact, that effect can be identified in the test results.

Control

A note on noise: control factors are those factors easily adjusted during product design and process design. Noise factors are those factors which are difficult or impossible to adjust during production or customer use. Selection of those factors easiest to adjust is the best procedure when test planning begins. Because the UDOS 2.0 model produces noise-free output (100% reproducible), only control factors are included in model experimental designs.

It is important to remember that for the effective use of the UDOS 2.0 simulation model for experimental simulation analysis, the correct factors and levels must be identified and developed during initial test planning. The model allows a comparative analysis of the <u>selected</u> factors and levels, with identification of the best combination of these. It must be remembered that this may not be the optimal solution to a process or product problem, the factors and levels of which may not have been defined.

Numerous works have been produced regarding the use of Taguchi analysis in problem identification and solving in industrial settings. The reader is encouraged to examine this material, including the fundamental work of Dr. Taguchi, for specific applications and techniques.

### 10.1 MATPCA EXPERIMENTATION RESULTS

A statistical analysis was performed on throughput and flow time (actual vs. simulated) for the validated model run. The results of this analysis are shown in Tables 10-1 and 10-2. These results form a baseline to which the quality characteristics from the experimental model runs are compared.

The orthogonal array developed during brainstorming is shown in table 10-3. It lists the factors and levels which will form the experimental design. The use of this array reduces the number of experimental runs from 81 to nine. The experimental runs are performed on the UDOS 2.0 model using the existing (AS-IS) conditions for FY88. Note that due to the fact that throughput was 100% for all experimental runs, it is now necessary to use average simulated flow time as the quality characteristic for comparative analysis. Table 10-4 gives the result of this analysis, beginning with the average flow times of each experimental run and showing the interaction among factors and levels. The Taguchi test matrix is shown to the right of these listings. The optimal configuration is given as:

FACTOR: A B C D

LEVEL: 1 3 1 1

This configuration is interpreted as the following: (1) Add one OC 3906 Jet Ignition Tester on first shift, (2) Add two welders on first and second shifts, (3) Add one OC 4286 Temperature Amplifier Test Stand on first shift, and (4) Add one BY09 skill code position to first shift. Note that the average savings in flow time is a (simulated) 243.64 vs.

302.16 hours for the AS-IS condition. This savings in flow time would need to be compared against the cost of implementing these changes. The justification of expenditures for these changes might be more applicable if applied to surge conditions, when this reduction in flow time might prove more valuable.

The detailed results of these runs by PCN may be found in appendix A. The computer generated analysis sheets contained in appendix A, which is formed from a LOTUS 123 spreadsheet program, contain an extensive Taguchi analysis using the quality characteristics of Throughput (simulated vs. actual) and Simulated Flow Time.

### 10.2 SURGE ANALYSIS

Surge production capability for this RCC was performed by running a model Usage Report using the FY88 data with the surge conditions for various weapons systems as reported by ALC Headquarters. The usage report was adjusted to show the surge conditions for manpower and equipment of a seven day work week and two twelve hour shifts. The analysis of this data shows that MATPCA is a robust production area, well able to meet projected surge conditions with the present level of manpower and equipment. It should be mentioned that the existing level of experience and expertise may be directly affecting the throughput and flow hours shown, and any change to personnel or equipment needs could have an effect on surge capability.

# MATPCA ELECTRICAL ACCESSORIES THROUGHPUT STATISTICAL ANALYSIS TABLE STATE / /0 - /

PART CONTROL NUMBER (PCN)	SIMULATED	FY 88 ACTUALS	% VARIANCE (SIM /ACTUALS)
30056A	86	87	-1%
30241A	574	523	9%
31151A	326	327	31%
34044A	159	158	1%
34128A	590	586	1%
34252A	126	126	0%
34253A	755	758	40%
34551A	105	103	2%
35023A	258	255	1%
35111A	114	114	0%
35113A	137	136	1%
35510A	68	65	4%
37719A	493	488	1%
38643A	143	136	5%
38645A	299	268	10%
38669A	147	148	-1%
38694A	287	289	-1%
38718A	371	369	1%
49315A	1016	1000	2%
49711A	236	231	2%
50217A	14	14	0%
50078A	161	160	1%
97133A	141	141	0%
98001A	94	92	2%
98093A	504	501	1%
61234A	104	105	-1%
SHOP AVERAGE	7,308	7,180	2%

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# MATPCA ELECTRICAL ACCESSORIES FLOW HOURS STATISTICAL ANALYSIS TABLE 6222 10-2

PART CONTROL NUMBER (PCN)	SIMULATED	G-019-C	% VARIANCE (SIM /ACTUALS)
30056A	78.81	408	-81%
30241A	269.95	264	2%
31151A	51.72	264	-80%
34044A	172.72	216	-20%
34128A	1204.78	240	80%
34252A	91.75	168	-45%
34253A	163.91	168	-2%
34551A	318.92	312	2%
35023A	298.99	360	-17%
35111A	75.22	192	-61%
35113A	131.44	192	-32%
35510A	163.08	312	-48%
37719A	125.24	192	-35%
38643A	187.46	192	-2%
38645A	1191.08	192	84%
38669A	154.79	312	-50%
38694A	108.86	216	-50%
38718A	281,85	336	-16%
49315A	1115.23	240	78%
49711A	445.84	216	52%
50217A	318.84	192	40%
50078A	115.02	192	-40%
97133A	96.84	288	-70%
98001A	338.63	360	6%
98093A	193.42	336	-42%
61234A	126.77	192	-34%
SHOP AVERAGE	302.16	252.0	17%

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# MATPCA L, (34) TAGUCHI ORTHOGONAL ARRAY THROUGHPUT EXPERIMENTAL RESULTS - FY 90 TABLE RESID 10-3

	EQUIPMENT	BACKSHOP	EQUIPMENT	MANPOWER	MACN	NORMAL WORKLOAD	OAD
EXP #	CUANTITY		CUANTITY	ASSIGNED	AVG	BEST	WORST
1	ADD 1 OC 3606	3 WELDERS ON 1°' SHIFT	ADD 1 OC 4286 ON 187 SHIFT	ADD 1 CODE BY ON 10' SHIFT	100%	THE SECOND	YNLOW
2	ADD 1 OC 3868	4 WELDERS ON 18' SHIFT	ADD 2 OC 4286 ON 1** SHIFT	ADD 2 CODE BY ON 1º* SHIFT	100%	1	THE
6	ADD 1 OC 3808	THE IST OF THE	USE OC 4286 ON 2"° SHIFT	ADD 4 CODE BY ON 14" SHIFT	±	7718	The same
*	ADD 2 OC 3006	3 WELDERS ON 10' SHIFT	ADD 2 OC 4286 ON 1°* SHIFT	ADD 4 CODE BY ON 187 SHIFT	99%	*	1
8	AD0 2 OC 3006	4 WELDERS ON 1°' SHIFT	USE OC 4298 ON 2"º SHIFT	ADD 1 CODE BY ON 157 SHIFT	100%	100	71168
•	ADD 2 OC 3806	2 WELDERS ON 187 SHIFT	ADD 1 OC 4296 ON 187 SHIFT	ADD 2 CODE BY ON 1°* SHIFT	100%	11/8	200
7	1 OC 3806 WITH 1/2 TIME	3 WELDERS ON 1°7 SHIFT	USE OC 4286 ON 2"® SHIFT	ADD 2 CODE BY ON 187 SHIFT	100%	100	The same
•	1 OC 2006 WITH 1/2 TIME	4 WELDERS ON 1°' SHIFT	ADD 1 OC 4286 ON 1** SHIFT	ADD 4 CODE BY ON 1°* SHIFT	100%	110	YOUR
•	1 OC 2000 WITH 1/2 TIME	2 WELDERS	ADD 2 OC 4286 ON 197 SHIFT	ADD 1 CODE BY ON 1°' SHIFT	100%	71000	YOULD

LSC-20497

# ANALYSIS OF EXPERIMENTAL FLOW TIME AVERAGES USING TAGUCHI METHOD (L.) TABLE \*\*\*\* 10 - 4

# **EXPERIMENTAL FLOW TIME AVERAGES -**

EXP. 1	251.22
EXP. 2	239.08
EXP. 3	238.65
EXP. 4	275.43
EXP. 5	237.96
EXP. 6	232.85
EXP. 7	276.63
EXP. 8	247.76
EXP. 9	251.12

NO NO	1	2	3	4
1 2 3	1 1 1	1 2 3	1 2 3	1 2 3
1 2 3	2 2 2	1 2 3	2 3 1	3 1 2
1 2	3	1 2	3	2 3

LSC-20493

L, (34)

FACTOR	LEVE	L	
1	1 2 3	242.98 284.75 258.50	
2	1 2 3	267.76 241.00	
•	•	240.87	
3	1 2 3	243.94 255.21 251.08	
4	1 2	246.77 249.52 253.96	

APPENDIX A

TAGUCHI ANALYSIS BY PCN

FOR EXPERIMENTAL RUNS

		[kenen]	SAMPLES	69	; ;;	: 3	: 55	: X	: 53	25	: <del></del>	3	•	•	•			
			SWOTIJART	n	· %	: 3	· \$	· %	**	3	25	*	3	•	9			
		194	PERCENT	0.05	2:3	-1.6	-6.58	-1.60	2.18	2.58	-1.60	-0.97	1.3	1.35	-2.86	90.0-	2.58	-2.86
05-Sep-89 PCA61234		38	EFFECT PER	92.8	94.2	91.2	92.2	91.2	94.7	95.1	91.2	91.8	93.9	94.2	98.1	12.7	95.1	90.1
		1111	PERCENT	1.36	2.94	-4.32	-0.55	-1.68	2.23	3.0)	-3.85	9.78	-2.30	-0.0	2.33	-0.00	3.07	-4.32
L9 ARRAT		FL 08	EFFECT	119.2	117.3	126.1	121.5	122.4	118.2	117.1	125.5	119.9	123.4	120.9	118.0	120.9	126.1	117.1
61234A	• •		FACTOR	-	4 2	~	=	3.5	~	C 1	<b>2</b> 3	C J	=	7	~			
ë	BEARTERS INDUCTIONS	186 781	RESMLT	95.0333	11.22807	91.22807	87.47348	12.91245	3	91.22807	121.52 89.47348	130.8 92.98245			ž	11.7	100	110.95 89.47348
		FLOW TIME	AF SOC. I	110.95	125.78	112.71	119.72	121.15	116.95	125.88	121.52	136.0			=	120.9	130.8	110.95
EL 19CA	FACTOR	-	EWEI	-	~	~	<b>~</b> >	-	~	~	~	-				w	_	*
ALTSIS ACC 3	FACTOR FACTOR	·	EKE EKE	-	~	~	~	~		~	-	~			<b>10</b>	AVERAGE	MAX I VAN	
	_	-			~	~	-	~	~	-	~	~						
ANDERNI EIPERINENT ANN. TSIS 15 : OC RECE	25	•			-		~	~	~	~	~~	~*						
769CH			3		~	~	~	~	•	~	-	•						

	HECK ENTRY AND 1515	1 3	1.15.15					LP ARRAY		15-5e1-89			
-	¥		 2	MA 1PCA		Ë	<b>3013</b>		_	PCA98093			
	FACTOR	FACTOR	FAC 108	FACTOR 1		BUARTERS IMBUCTIBUS	* # \$2						
	-	-	٠	-	FLOW TIME			108			Pul	Tududki	_
ij	J. LEREI	LE ME	IENEI	E	#ES#	ESE.	FACT	EFFECT	三	EFFECT	PERCENT	IMBILE LIGHS	Saméi s
	-	-	-	-	171.4	114.5952	-	176.5	2	99.1	6.31	144	
~	-	~	~	~	13.7	78.30187	~	178.3	~	4.0	<b>6.</b> 23	305	
~		~	~	~	17.	9.30107	~	189.4	Ŧ	18.3	×.	\$0\$	, ~
•	~	-	~	~	162.93	19.30107	-	179.2	≈	99.1	0.31	300	, ~
~	~	~	~	-	17.3	98.30107	=	183.3	3	98.3	-0.54	908	. ~
•	~	~	-	~	174.45	100.3460	-	181.7	6	9.66	0.23	586	• •
~	~	-	~	~	163.17	98.38187	ü	179.5	3	49.7	<b>6.8</b> /	695	
-	~	~	-	~	192.54	91.05825	ິວ	185.1	≈	7.86	-0.43	304	, ~
•	~	~	~	-	172.44	192.44 90.3010/	Ü	1.6.1	3	48.4	÷.	705	, ~
							_	180.5	3	99.1	6.3	3	1
							3 2	1.4.1	2	99.0	0.23		
			1 <b>8</b> 124		1633	=	~	1 184.6 -1.	2	98.3	-0.54	•	
			AVERAGE	***	181.4	98.8		181.4	-0.00	98.8	0.00		
			MAX I MUA		192.54	192.56 100.5952		189.4	2.70	49.7	0.87		
			# IN I REF	_	171.40	171.43 98.05825		176.5	-4.4	98.3	-0.54		

Ī	COL EXPERIENT AND 1515	1	1,1815					L9 ARRAY		5-Sen-89			
••	¥		: 2	#16C		Ž	110006		_	PCA98001			
	<b>8</b> 1373	***************************************	202.00	******		BBARTERS							
		į į –		Ĭ -	FLOW TIME		# 22	3	<u> </u>	Tuon	Į.		-
<u>=</u>	B. LEWEL	ונעד	LENEL	LEWEL	RESHL T	RESULT.	FACTOR	EFFECT	PERCEN	FFFECT	PERCENT	INDRUCTIONS	27 27 27 27
_	-	-			104.85	101.7241		339.2	8.07	100.6	0.63	60 m	
~	-	~	~	~	29.05	299.05 102.1276	4.2	356.2		100.0	0.02	? `\$	
~		~	~	~	313.79	17.0734	~	411.1	-11.4	99.3	-0.65	: 3	<b>:</b>
•	7	-	~	~	413.56	8	-	460.2	-24.78	101.3	× -	÷ 🔾	: :
_	~	~	~		296.76	17.6734	1 2	318.2	13.7	100.0	90.0	÷ 😘	= 3
•	~	~		~	294.13	102	~	328.1	11.05	48.5	-1-	. 3	<b>?</b> 7
_	~	_	~	~	492.28	102.1276	- 0	354.6	38.	101.2	97		: 3
_	~	~		~	364.75	8	<b>C</b> 3	386.3	7.7	99.3	-0.65	: ~	2 5
•	m	~,	~		374.26	15.74468	٤3	365.6	0.8	99.3	-0.65	÷ <del>•</del>	<b>: :</b>
							-	357.3	3.13	98.4	÷-1-	. •	• •
							12	361.8	1.9	102.1	2.15	. 🗢	•
			TO TAK		3319	868	~	387.4	-5.03	99.3	-0.63	• •	• •
			AVERAGE	804	348.8	4.4		368.8	9.6	6.99	0.00		
		-	RAXING	_	472.28	192.28 102.1276		460.2	13.73	102.1	2.15		
			MINI MUN		290.76	290.76 95.74468		318.2	-24.78	98.4	-1.49		

		194277	SALPHAS SAMELES		\$ <b>9</b>	<b>S</b>	99	\$ <b>6</b>	43	98	99	98	•	•	9			
•		191	PERCENI	0.70												0.00		-0.36
05-Sep-89 PCA97133			3													-0.00 99.2	1.95 99.9	-2.12 98.8
L9 ARRAY		FLOW 11RE													84.5	85.5	₽7.4	63.9
PCN: 97133A	PUARTERS .	194 481	AESULT FACTOR	102 0 1	1.83726 A 2	98.83720 A 3	78.83726 8 1	1.63726 8 2	1.92473 10 3	1.83720 C 1	98.83720 C 2	1.63720 C 3	-	<b>9</b> 2	13 13	4.2	102	.83720
	_	FLM 11K	AESAL!	79.7	14.17 H	PA.69 31	43.45 71	87.76	14.54	15.12 M	85.±	12.4 21			<b>%</b>	15.5	98.2	83.65 98.83720
MLTSIS RCC : MATPCA	A FACTOR FACTOR	_	TENEL LEWER	-	2 2	<b>n</b>	7	-	1	2	-	2 1			161 <sub>A</sub>	AVERAGE		
ONCOL ESPERATENT ANALYSIS G : AC RCC	FACTOR FACTO	J • •	. LEWEL LEWEL	-	1 5	m 	~	7 ~	~	-	~	m m						
16 : 73				-	~	~	~	~	•	~	-	•						

The state of the s

		1 HKUFU!	SAMPLES SW		"	7	69	. <del>~</del>	\$2	77	•	"	•	•	•			
			SMOI L JAMAN I			2	7.3	27	2	2	2	27	•	•	•			
		184	PERCENT	0.50	-0.05	-0.52	-6.83	-0.52	5.3	9.11	-0.05	-0.05	9.58	1.35	-1.93	-0.0	1.35	ă
65-Sep-89 PCA50078		INRU	EFFECT	17.9	47.3	9.96	96.5	9.9	78.6	47.4	97.3	47.3	97.9	91.6	95.4	9),3 -0	98.6	* **
		1116	PERCENT	1.13	3.23	4.36	1.02	-2.16	1.14	0.35	-4.63	4.8	-2.70	1.99	9.73	9.0	4.08	27
LF ARRAY		F100	EFFECT	103.2	101.0	109.0	103.3	106.7	103.2	103.8	109.2	100.1	107.2	142.3	103.7	164.4	109.2	3
<b>1695</b>	* * \$		FACTOR		4 2	M 4		3 2	~	-	<b>C</b> 3	2	=	7 (	~			
Ş	DELATERS INDUCTIONS		RESULT.	164.4 97.72727	#.43413	97.26627	<b>94.52854</b>	17.24627	=	17.26627	74.52054	10.43013			17.	9.3	=	139C) 98 C9
		FLOW TIRE	ESE.	¥.	14.24	97.63	14.4	101.H	17.19	101.55	19.13	115.42			\$	¥.	115.42	• 41
MIPCA	R FACTOR	•	IENEI	-	~	~	•	-	~	~	~					<b>**</b>	畫	=
Macrisis ACC :		•			~	<b>~</b>	~	~		~	-	~			# E	MERAEE	MAX 2 MAN	
	FACTOR	•	3	-	~	~	-	~	m	-	~	-						
		_	-	_	_	_	-											
BECH EPORTIESS C : CC	FACTOR	<b>4</b>	B. LENEL		-		~	~	~	~		_						

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1	DECIMENT		1515					10 4004		A5-Caa-40			
. 3	¥		뀰			ä	<b>8</b> 4517 <b>8</b>		_	PCA50217			
						PRARTERS -	-						
	felm	FETE	R FACTOR FACTOR	FACIE		110 CT 10							
	•	-	u	-	FLM TIRE			FLOW	<b>=</b>	2	12	I HOHOTT!	-
	. LEME			ENE	ESEL!	RSM.	FACIE	EFFECT	PERCENT	EFFECT	PERCENT	EMBINC TONS	SAMO
-	-			-	24.69	<b>11.29577</b>	-	<b>29.5</b>	÷.56	93.1	2.5	142	=
~		~	~	~	323.39	*	7 4	143.7	<b>6.</b> 43	\$2.2	-7.43	91	
m	-	~	~	~	<b>3.5</b>	*	M	310.9	-7.44	2.5	1.7	2	
•	~		~	~	21.4 21.4	2	=	276.2	4.10	93.1	5.27	: =	
•	~	~	~		38.7	2	<b>8</b> 2	316.1	-10.44	90.0	*.·	: =	
•	~	~	-	~	29.42	44.4446	~	269.8	4.34	12.2	-7.63	; "	
~	~		~	~	282.59	2	7 3	268.0	6.9	85.3	-3.53	=	
•	~	~	-	~	336.3	2	£ 2	308.2	-7.61	99.0	1.76	: =	
•	~	~	~	-	319.9	2	3	207.9	9.05	90.0	1.7	2	-
							-	295.1	-2.45	93.1	2.33	;	
							7 (	271.7	5.69	62.2	-7.03	•	_
			101A		2382	ž	2	297.4	-3.24	90.0	1.76	3.	
			MEDIE	144	<b>288.</b>	2		288.6	3.	4.88	90.0-		
				=	330.3	336.3 19.29577		318.1	÷:	93.1	5.27		
				-	20.02	207.02 64.66666		263.7	-16.44	82.2	•		

=	ENTRINEM		AMM YSIS					LY ARRAY		15-See-29			
	*		<b>3</b>	<b>1</b> 110	_	Ë	497114		_	PC449711			
	54C100	FACTER	FACTOR			OUARTERS TABACTTARS	* a						
	-	-		-	FL# 71#			F. 98	7176	2	Ž	] manam ]	***
ď			덩	IERE E	FESH.		FACTOR	EFFECT	PERCENT	EFFECT	PERCENI	INDECTIONS	SAMPLES
	-		-	-	469.9	1 M.01709	-	382.8	7.42	93.6	9.0	/11	•
	-	~	~	~	X2.X	96.67H3	4.2	397.1	3.97	13.5	7.	153	25
	-		•	m	¥.2	7.M.W.	7	46.7	-11.4	12.2	-1.0	153	139
	~	-	~	~	3.33	18.19607	=	530.0	-28.35	11.1	-1.28	153	25
	~	~	m	-	313.74	12.01045	1 2	350.0	15.36	43.9	0.87	25	142
	~	~	-	~	316.9	97.41935	~	359.8	12.99	93.5	15.0	32	151
	~	-	~	~	\$2.7	91.50326	<u>.</u>	396.8	£.	7.5	87.1	153	9
	~	~		~	#3.6)	43.67 72.81MS	<b>C</b> 3	436.6		97.0	-6.30	153	~
	~	<b>~</b>	~		416.4	12.15464	د ع	407.2	<u>.</u>	11.7	1.47	153	1
							=	464.1	3.25	93.0	-6.11	9	•
							7	403.7	2.37	95.0	5.05	•	•
			1012		3722	3	~	436.8	-5.62	91.3	-1.94	*	•
			AVERAGE	***	413.5	13.1		413.5	9.00	93.1	0.00		
				_	541.71	561.71 97.41935		530.6	15.36	45.4			
				_	313.74	313.74 90.19607		350.0	-28.35	91.3	-1.94		

		_	SAMPLES	<b>203</b>	\$75	7/5	<b>•</b>	£ 5	3	<b>*</b>		: :S	•	•	•			
		Induite	INDUCTIONS	426	£ \$2	\$2\$	\$25	: 3	?	\$7\$	\$25	22	-	•	э			
		104	PERCENI	=======================================	0.26	4.42	.5.30	2.0	2.7	16.1-	9.80	9::	-1.36	4.38	9.98	-0.00	3.61	
65-Sep-89 PCA49315A					106.6	107.3	100.7	109.5	108.8	104.3	107.2	167.5	164.9	106.7	107.4	166.3	109.5	
		71K	PERCENT									-2.84				9.0	4.27	
L9 ARRAY		7.5	EFFECT	1166.3	1276.6	1777.4	1457.0	1125.3	1138.3	1166.9	1278.3	1275.4	1167.9	1275.9	1276.0	1240.2	1457.0	
\$17 <b>\$</b>	* *		FACTOR	~	4 2	~ 4	-	7 1	~	5	<b>2</b> 3	£ 3	-	9.2				
ä	BEATERS TUBBETT BAS		RSW.	1237.48 95.9538	107.5238	14.7142	102.657	109.5238	107.4803	103.2380	107.5238	109.1428			35	18.3	548.13 109.7142	
		FLW 11K	RESM !	1237.48	1123.3	1136.16	1566.13	1124.54	1137.2	1545.33	1125.97 109.5238	1141.35			11162	1246.2	1548.13	
	81.53	-	LENEI	-	~	~	~	-	~	~	~						-	
# 75 FF .		3	LEWEL		~	~	~	m	-	~		~			101A	MERAGE		
EPPERIMENT ANNUTSIS			r tener		~	~		~	m	-	7							
222		•	r tra	-	-	***	~	~	~	~	~	~						
15 E					~	~	•	~	•	~	•	•						

( ;

PERINDI	I ENCRINENT ANALYSIS					LY MRAY		15-Sep-19			
<b>-</b>	Ħ	2		į	387184		_	PCA38718			
ACTOR FA	11 F F ACT 0	FECT		DEMANTERS INDECTIONS	= #						
-	-	-	FLOW THE TWEN PUT			F.E	1186		2		5
		LERE	RESE ?	RESH.7	FACTOR	EFFECT		EFFECT	PERCENT	IMPRC7 : GAS	SAMPLES
_	-	-	27.34	17.70972	-	211.0		97.5		151	128
-	7 7	~	21.E	17.34942	4 2	281.2		99.7			181
-	2	~	71.71	77.34942	~	282.5		97.3		881	
~	7	~	¥.5	77.34642	-	286.9		17.5		**	- E
~	2	-	281.49	97.34642	2 1	282.1		97.3		19.C	183
~	-	~	3.5	IM.3956	~	281.7		49.7		187	961
~	~	~	211.71	97.34642	5	281.0		99.6		991	=
~	~ ~	~	245.76	7.34H2	7 3	282.0		97.3		19.9	=
-	~	-	282.74	77.34642	C J	281.4		97.3		188	183
					=	281.2		97.5		>	•
					1 2	281.4		49.7		•	
	<b>10</b>		2534	<b>3</b>	~	282.1		97.3		• •	•
	MERAEE	<b>3</b>	201.5	<b>98.</b> 2		281.5	0.00	98.2	4.40		
		*	202.94	292.94 104.3954		282.5		99.8			
		=	279.34	279.34 97.34642		280.9	•	17.3	•		

San San													
16 cm		ENTERIORIST ANN. 1515 OC. DCC.	555 FG ::	2		ğ	396985	L9 ARRAY		65-Sep-89 PCA38694			
	FACTOR		7.			BOARTERS TIRRECTTORS	* *						
		-	u	-	FLOW TIME		,		1186		JR4	Ingnami	=
Í					RESME 1	RESM.	FACTOR		PERCENI		PERCEN	IMBUC I LONS	SAMPLES
	-	-	-	-	117.32	17.1133	-	112.4	1.03	96.4	-0.86	103	901
~	-	~	~	~	19.5	11.71777	7 7	114.5	-6.83	100.0	4.73	591	[4]
~	-	~	~	~	110.4	7.39393	~	113.0	-4.2	46.4	4.12	S 9 1	77
•	~	-	~	~	119.46	7.39393	=	116.8	7.7	8.8	-0.45	: ≘	3
~	~	~	~	-	114.49	14.56	1 2	112.2	1.27	4.6	6.33	165	<b>₹</b>
•	~	~		~	19.45	=	~	109.9	3.23	4.6	6.12	951	35
~	~	-	~	~	119.47	3	- 5	113.0	6.51	9.0	÷.4.	3	145
-	~	~	-	~	112.20	112.20 99.39393	£ 3	112.9	0.60	99.0	-1.29	SAL.	144
<b>-</b>	~	~	~	_	19.75	11.7177	C 3	114.9	-1.12	100.0	6.73	\$91	163
•							-	113.9	-0.28	98.8	-6.45	•	•
							7 (	112.8	69.0	3.5	6.33	•	•
			11		1022	E	-	114.1	-0.4	43.4	0.12	9	•
			AVERAGE	<b></b>	113.6	#.3		113.4	9.00	99.3	-0.00		
				-	119.48	119.48 199.4060		110.6	3.27		0.73		
					14.45	169.45 97.68737		109.9	-4.54	4.	-0.84		

		<b>₹</b>	£ 7515					C AFRA	•	5-Sep-19			
ŝ	# · · · ·		<u>=</u>	MINC		ĕ	38793			PCA30469			
	faci <b>a</b>	FACTE	FACTOR	FACTOR		OUARTERS INDUCTIONS							
		-	·	-	FLOW TIME			F.08	二三	28%		14040	5
	. LEWEL	iere E	EXE	E	ACSE.		FACTOR	EFFECT	PERCENT	EFFECT	PERCENI	IMPUC I I DNS	SAMPLES
	-		-	-	142.44		-	142.3	6.1	100.5	<b>6.3</b>	35	•
~		~	~	~	142.32		7 4	139.0	2.55	191.	-6.15	22	_
~	-	-	~	~	142.03		~	146.5	-2.74	100.0	-6.15	ĸ	~
•	~	-	~	~	139.4	3	=	141.1	1.05	÷.	-0.15	33	1
~	~	~	~	-	- M.		2 1	142.7	-1.13	186.5	6.30	:2	1
•	~	~		~	139.01		~	#.·	-0.9¢	100.0	-4.15	1,0	~
~	~	-	~	~	141.59		C 3	142.9	-0.21	100.0	÷.15	22	_
-	~	~	-	~	147.04	3	<b>C</b> 3	<b>.</b> ₹	¥.	.≎ .≎	<b>6</b> .3	27	1
•	~	~	~	-	134.85		( )	146.9	1.25	100.0	÷.15	2	_
							-	14.1	-1.05	100.0	÷.15	•	
							1 2	141.0		18.5	<b>6.3</b>	•	
			101A		1283	7	~	142.7	-1.09	100.0	-6.15	•	
			MERAE	w	142.4	18.2		142.6	9.9	100.2	0.0		
			HAX 1868	-	136.85	39.85 101.3698		146.5	2.55	100.5	o. 36		
			M) M) M	=	136.8	3		139.6	-2.74	100.0	-0.15		

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		EIPERINENT ANN. 1515	k rsis			į	;	LY ARRAY		02-Sep-89	
=	<b>4</b>		<u> </u>			ž	X			PCA38645	
						PUARTERS					
			FACTOR	FACTOR		IMPACTIBAS .					
	•	~	u	-	FLOW TIME			10 J	] <u> </u>	- KAR	E
Í	ERE.	E		I W	AE SAL 1	RESM.	FACTOR	EFFECT	PERCENT	EFFECT	PERCENT
			-	-	1.E.E	164.04 PT.04761	-	14.6		9.66	
~		~	~	~	75.56	<b>99.33774</b>	A 2	115.2		3.	9.92
~	-	~	~	~	101.73	11.67549	~	<b>8</b> 5.5		4.66	-0.19
•	~	-	~	~	116.03	16.63 98.67549		107.7		10.6	-6.51
~	~	~	~		119.35	19.55 101.3245	1 2	11.4		100.0	4.25
•	~	~	_	~	19.93	102.0134	~	15.9	2.57	100.0	9.38
~	-	-	~	~	101.17	2	 -	7.7		100.1	0.38
-	m	~	-	~	79.33	79.35 99.33774	<b>C</b> 3	89.3		13.1	-0.63
-	m	~	~		75.47	19.33774	۳	107.5		100.0	4.25
							=	100.5		9.6	0.15
							1 2	45.7		100.5	6.7
			<b>10</b>		#	E	~	9.6		98.9	-0.8
			AVERAGE		7.7	4.7		98.4	6.0	99.7	-0.00
				_	119.55	19.55 102.0134		115.2	13.13	160.7	0.92
				_	75.96	75.96 98.67549		85.5	-17.03	98.9	-0.86

į	I EIPERINEM ANALYSIS	1 1 1 1	L TSIS					L9 ARRAY		05-Sep-89		
=	×		ž			į	38434			PCA38643		
						BUARTERS						
	FACTOR	FEIN	SACTE.	FRIB		INST. TOAS	*					
	~	-	·	-	FLW TIKE			F. S.	1		2	
Ī	1. LERE	THE ST	LENEI	IENE I	RSM.	ESE. 1	FACTOR	EFFECTI			PERCENT	
~	-		-	-	93.18	101.7543	-	101.1		103.5	0.40	
~		~	~	~	107.34	107.94 104.3478	4 2	111.8		101.5	-1.33	
m	-	~	~	~	125.21	104.3471	× 4	109.2		103.6	0.73	
•	~	-	~	~	102.75	104,3478	~	106.5		102.8	÷.	
•	~	~	~	-	115.18	14.3478	1 2	109.1		164.3	¥:	
•	7	~	-	~	117.53	15.7847	~	114.2		101.5	-1.33	
~	m	-	~	~	123.5	102,1739		104.9		100.6	-2.17	
•	~	~	-	~	144.12	164,3478	7 3	103.5		104.3	₹.	
•	~•	-	~		#.83	164.34/8	£ 3	121.3		103.6	9.73	
							-	102.7		103.5	0.60	
							1 2	114.3		100.0	-2.64	
			10 IA		£	<b>32</b>	~	110.7	-0.70	104.3	¥.:	
			AVERAGE		109.9	162.9		109.9	9.0	102.9	6.00	
			Rek I nga	_	125.21	125.21 104.3478		121.3	\$.5	104.3	¥.	
				_	13.16	13.18 15.78947		102.7	-10.35	100.6	-2.17	

ŧ,

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-89 19		TARD PUT		101.3 4.38					6.5 -0.48			·			90.0 0.191	101.3 0.38	
05-5ep-89 PCA37719		TIME 1		166.00	_				-9.05 10						0.00	100.00	
L9 ARRAY		FLOW TH	•				120.9	121.2	120.7	120.7	121.0	120.5	120.7	171.7	110.7	121.2	
37719A	* *	FACTOR	=	A 2	M	-	8 2	~	. 3	C 3	£ 3	=	1 2	~			
Ş	PUMPTERS IMPACTIONS	THES POT		101.1952	101.1952	101.1952	101.1952	101.6129	101.1952	101.1952	101.1952			£	101.0	121.57 101.6129	
		FL88 718E RESM.7	11.3	120.13	121.35	139.1	129.88	121.09	129.01	121.57	121.05			1887	120.8	121.57	
MIPCA	FECTOR		_	~	m	~	-	~	~	~	_				***	_	
LTSIS RCC :	FACTOR	تو الأيو	-	~	m	~	~	-	~	-	~			70 7	AVERAGE	HAX I NAM	
EVERINENT ANALYSIS BE RC	FECT 8	- THEI	-	~	~	_	~	~	-	~	~						
EPPERIOR A	FECT 8	- 124		~		~	~	~	~	~	~						
Ē .:																	

<b>a</b>	THE EXPERIMENT AND LESS OF THE PARTY SERVICE AND LESS OF THE PARTY			2	-	E	355104	LY ARRAY		05-5ep-89 PCA35510A				
	FRIE	FETE	FECTOR	FACTOR		PULATERS INDUCTIONS	• •							
	-	-	u	-		THE PUT		F108	]HE	TARK	787	I SEEDER!	18	
ď	TENET.		LENEL LENEL	18 18 18		RESM.T	FACTER	EFFECT		EFFECT	PERCENT	INDUCTIONS	SAMPLES	
	-					=	=	143.9		192.1	-5.23	=	ŧ	
	-	~-	~	~		106.25	1 2	138.6		115.9	1.53	35	**	
_	-	~	~	~		3	~	164.4		105.2	-2.33	35	75	
_	~	-	~	~		163.125	=	14.9		163.1	-4.27	32	33	
_	7	~	~	-		106.25	1 2	153.4		107.3	÷.÷	37	Ā	
	~	~	-	~		138.2352	~	145.1		112.7	4.66	3	7	
_	~		~>	~		164.25		₩.		115.9	7.57	35	*	
_	~	~	-	~	157.17	19.375	<b>C</b> 3	.X.		163.1	-4.77	75	2	
_	m	m	~			8		147.0		104.2	-3.50	25	37	
								152.8		102.1	-5.23	3	•	
							1 2	144.2		116.9	6.53	.9	•	
			101A		1324	69	~	146.0		104.2	-3.30	•	•	
			399344	فعو	10.7	10.7		147.7	-0.00	107.7	0.00			
			AAK SHAN	-	149.05	149.05 138.2332		166.4		116.9	8.53			
				_	126.43	8		138.6	-8.65	102.1	-5.23			

FACTOR FACTOR FACTOR   INDUCTIONS =		CIPCLIECE	1	AME TSTS	1981		i		19 ARTAY		12-Sep-19			
FACTOR FACTOR   1004/710MS =   FLOW   TIME	=	¥		 Z	2	_	ë	2 2 2 3 3		_	PCA35113A			
EVEL   LEWEL   LEWEL   RESMLT   RESMLT   FACTOR   EFFECT   FERCENT   EFFECT   FERCENT   INBUCTIONS			_	TACTOR	FACTER		BUARTERS IMPUCTION	* n						
				Ų	-	FLOW TIME		ı	1013	I WE	1 HKB	<b>1</b>	HAHAM)	
1 122.45 100 A 1 126.2 2.76 95.7 0.81 62 2 127.36 94.2020	Í			ENEL	15%	RSE.	FESET.	_	EFFECT	PERCENT	EFFECT	PERCENI	THE BELLIGING	
2 129.34 94.2029	<b></b>			-		122.45	3	~	124.2	2.76	15.7		7.9	C7
3 124.72 92.75342 A 3 132.1 -1.74 93.2 3 135.22 92.75342 B 1 129.9 -9.09 95.2 1 127.07 92.75342 B 2 130.4 -0.43 93.2 2 127.03 101.8181 B 3 128.9 0.72 96.3 2 131.92 92.75342 C 1 128.4 1.09 96.2 3 133.5 92.75342 C 2 131.8 -1.54 93.7 1 130.87 94.20289 C 3 129.2 0.44 92.8 B 1 127.5 1.74 95.7 127.8 94.9 133.1 -0.22 96.3 135.22 101.0101 132.1 2.76 96.2 122.45 92.75342 120.2 1.74 92.8	~	_	~	~	~	129.34	PA.20289	٧ ٢	131.1	-1.00	95.8		: 3	<b>;</b>
3 135.22 92.75342 B 1 129.9 -0.09 95.2 1 127.07 92.75342 B 2 130.4 -0.43 93.2 2 127.03 101.8181 B 3 128.9 0.72 96.3 2 131.92 92.75342 C 1 128.4 1.09 96.2 3 133.5 92.75342 C 2 131.8 -1.54 93.7 1 130.87 94.26289 C 3 129.2 0.44 92.8 B 1 127.5 1.74 95.7 B 2 130.1 -0.22 96.3 1168 654 B 3 131.8 -1.54 92.8 135.22 101.0181 132.1 2.76 96.2	~		~	<b>m</b>	~	126.72	72.75362	~	132.1	1.7	93.2		5 5	3 7
1 129-07 92-75342 B 2 130-4 -0.43 93-2 2 127-03 101-8181 B 3 128.9 0.72 94.3 2 131-92 92-75342 C 1 128.4 1.09 96.3 3 133.5 92-75342 C 2 131.8 -1.54 93.7 1 130-87 94-20289 C 3 129.2 0.44 92.8 1164 654 B 3 131.8 -1.54 92.8 135-22 101.0181 132.1 2.76 94.9 122-65 92-75362 126.2 -1.74 92.8	•	~	_	~	~	135.22	12.7332	=	129.9	-0.09	95.2		5 4	3
2 129-83 101-8181 B 3 128.9 0.72 96.3 2 131.92 92.75562 C 1 128.4 1.09 98.2 3 131.5 92.75562 C 2 131.8 -1.54 93.7 1 130-87 94.20289 C 3 129.2 0.44 92.8 1168 654 B 3 131.8 -1.54 92.8 1159-8 94.9 129.8 0.00 94.9 122.65 92.75562 126.2 -1.76 92.8	~	~	~	~	-	129.07	12.75342	7 4	130.6	-0.63	13.2			5 4
2 131.92 92.75362 C 1 126.4 1.09 96.2 3 133.5 92.75362 C 2 131.8 -1.54 93.7 1 130.87 94.26289 C 3 129.2 0.44 92.8 8 1 127.2 0.44 92.8 8 1 127.5 1.74 95.7 8 2 130.1 -0.22 96.3 1164 854 8 3 131.8 -1.54 92.8 135.22 101.0181 132.1 2.76 96.2 122.65 92.75362 126.2 -1.74 92.8	•	~	~		~	127.63	101.111	~	128.9	0.75	5.36		<b>.</b> 5	<b>5</b> 3
3 133.5 92.75342 C 2 131.8 -1.54 93.7 1 130.87 94.20289 C 3 127.2 0.44 92.8 1 127.5 1.76 95.7 1 127.5 1.76 95.7 1 127.8 1.36 -1.54 95.7 1 129.8 94.9 129.8 0.00 94.9 1 135.22 101.0181 132.1 2.76 96.2 1 122.65 92.75362 126.2 -1.76 92.8	~	~	_	~	7	131.92	92.75342	T 3	128.4	1.09	98.2		3	?
1 130.87 94.20289 C 3 127.2 0.44 72.8  B 1 127.5 1.74 95.7  B 2 130.1 -0.22 96.3  1164 654 B 3 131.8 -1.54 92.8  129.8 94.9 129.8 0.00 94.9  135.22 101.0101 132.1 2.76 98.2  122.65 92.73362 126.2 -1.76 92.8	-	-	~	-	~	13.5	12.75362	<b>C</b> 3	131.8	¥	43.7		3	7
1164 654 9 3 131.8 -1.74 95.7 129.8 94.9 129.8 0.00 94.9 135.22 101.0101 132.1 2.76 98.2 122.65 \$2.73362 126.2 -1.74 92.8	•	~	-	~	-	130.87	94.20289	C 3	129.2	÷.	42.8		. *3	4
1148 654 9 3 131.8 -1.54 92.8 129.8 94.9 129.8 0.00 94.9 135.22 101.0101 132.1 2.76 98.2 122.65 92.73362 126.2 -1.76 92.8								-	127.5	1.76	95.7		, 3	;
1168     654     8 3     131.8     -1.54     92.8       129.8     94.9     129.8     0.00     94.9       135.22     101.0181     132.1     2.76     98.2       122.65     92.73362     126.2     -1.76     92.8								7 (	130.1	-4.22	96.3		•	
129.8 94.9 129.8 0.00 94.9 135.22 101.0101 132.1 2.76 98.2 122.65 92.73342 126.2 -1.76 92.8				<b>=</b>		3	\$	~	131.8	¥.;-	12.8		3	•
135.22 101.0101 132.1 2.76 98.2 122.65 92.73362 126.2 -1.76 92.0			_	MERCE		139.8			129.8	0,00	94.9	0.00		
122.65 92.73342 124.2 -1.74 92.8			-	E C		135.22	101.9101		132.1	2.76	98.2	3,48		
			_			122.65	12.75362		126.2	-1.74	92.9	-2.15		

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	EPPERIMENT ANN, 1515  OC. 100	. 1515 150 :	# IPC		į	351114	L9 ARRAY	_	05-Sep-09 PCA35111A			
				_	PURTERS	* *						
ļ.,	ļ ~			FLW TIKE		# #	FL08	36.1	286	12	THEOREM	`.
	EKE	LENEL		159K-1	RESH. 7	FACTOR	EFFECT	PERCENT	EFFECT	PERCENI	INDUCTIONS	SAMPLES
-	~			73.12	73.12 94.11744	-	72.8	-0.24	97.0	7.7	35	7
	~	~	~	7.0	18.38789	V 4	12.7	-0.17	19.6	1.2)	62	10
-	~	~	~	73.11	11.38709	~	72.3	₽.	98.4	0.0	79	•
~	-	~	~	72.03	96.38789	=	1.,1	-6.69	17.0	₹ -	79	19
~	~	~	-	72.00	94.34709	1 2	72.1	6.7	48.4	69.0	79	•
~	~	-	~	~	74 101.8647	~	73.0	-0.61	9.66	1.27	33	*
~	-	~	~	72.81	1.32/01	- 3	73.1	.0.66	1.8	-6.17	29	19
~	~	-	~	12.67	18.38709	<b>C</b> 3	72.0	11.0	98.4	0.0	79	19
~	~	~	-	7.7	11.30/09	ر د	12.7	-0.12	98.4	69.0	~\$	10
						-	72.4	0.26	97.0	-1.36	•	•
						9.2	73.0	-0.5	9.66	1.27	•	•
		181AL		153	ŝ	~	72.4	0.75	78.4	6.09	o	0
		ave eage	w	72.6	98.3		72.6	0.00	 	-0.00		
			=	×	74 101.867		73.1	0.77	4.4	1.27		
		HEN! HON	-	71.78	71.98 94.11764		72.0	-0.66	97.0			

		TABLETT ETPERIMENT ANNETSIS	11535					L9 ARRAY	*	42-Sep-19			
#C:	¥		£	MIPC.		ë	354234		<b>*</b>	CA35023A			
						<b>WARTERS</b>							
	FACTOR		FACTOR FACTOR	FECTER		IMPACT 1045	E						
	•	-	•	-	FIRE THE	_			<b>三条</b>	2	701	LHAGBALL	_
1	, CE .		79.9	- 6116	100	•	FACTOR	(13333)	PERCENT	EFFECT	PERCENI	INDUCTIONS	SAMPLES
-	4 -		-	-	X	102.0979		198.2	3.20	101.3	6.23	<del>2</del>	146
• •	-	• ~	٠,	٠ ~	194.4)	101.2345	7 4	195.3	4.65	8 8	₽:;-	291	3
• •		• •	• •	, ,,,,,	192.07	100.6172	~	220.8	-7.65	101.9	9.78	162	163
• -	٠ ،		. ~	, pri	216.47	161.1518	_	214.9	£.95	101.9	6.87	162	3
	. ^	۰ ^	. ~	-	184.72	100.6172	1 2	196.8	3.88	101.2	6.17	791	163
•   •	• •	. ~	• -	٠ ~	184.54	97.54097	M	202.6	1.07	180.0	-1.0	164	160
• ^		, -	. ~	. ^	719.72	101.8519		201.6	1.5	100.5	-6.55	791	165
•	•	• •	• -		711.67	101.8518	23	213.9	-4.45	101.6	6.5	795	165
• •	ე ~	. ~	. ~	• -	231.15	101.8518	-	198.8	2.90	101.0	-0.03	791	165
-	•	•	•	•			_	208.1	1,1.	101.5	9.46	9	•
							<b>3</b> 2	199.5	2.60	100.2	-0.83	3	•
			TOTAL		1843	910		206.7	-0.96	101.4	u.38	•	•
			MERAGE	*	2H.B	101.1		204.8	-0.00	101.1	90.0-		
			HAX I WOO	=	231.15	231.15 102.0979	_	220.8	4.45	101.9	6.87		
			MANINI	<b>5</b>	3.5	184.54 97.54697	1	195.3	-7.85	100.0	-1.04		

	<b>BECHI EYPERINENE AMALYSIS</b>		LYSIS					L9 ARRAY		15-Sep-19			
3	¥		 g	MATPCA		ä	345514		_	CA34551			
						WEATERS	**						
	FACTOR	FACTOR	FACIN	FACTE		IMPECTIONS.							
	•	-	4.0	-	FLOW TIME			2	¥	3	<b>Ξ</b>	INKUFUI	=
=	. LEWEL	Ħ	רבענו וכענו	EME EME	- ESE	<b>ESM</b> 1	FACTOR	EFFECT	PERCENT	(FFEC)	PERCENT	INDUCTIONS	SAMPLES
	-				315.57	102.1274	~	315.8	0.03	18.3	-6.52	=	*
~	-	~	~	~	315.98	165.4545	4 2	316.2	-0.0	19.9	-0.05	s	•
~	-	m	m	~	315.9	105.4545	M	316.2	-0.45	165.5	ž.	æ	•
•	~	-	~	m	315.91	165.4545	=	315.9	0.65	104.3	-4.52	\$\$	~
•	~	~	~	-	316.38	105.4545	1 2	316.1	-0.00	105.5	 	52	~
•	7	m	-	~	316.34	163.7637	~	316.2	-0.05	104.9	-6.62	X	•
~	~		~	7	316.36	105.4545	1 3	315.9	0.05	163.8	-1.08	£	•
-	m	~	-	~	315.91	105.4545	C 2	316.1	-0.01	105.5	7.0	£	•
•	~	~	~	_	316.46	105.4545	£ 3	314.2	5.0	105.5	9.54	\$	•
							=	316.1	-0.01	164.3	-0.52	•	
							<b>)</b> 2	316.2	20.0	104.9	-0.02		
			10TA		2045	Ŧ	~	315.9	9.0	105.5	.x.	<b>.</b>	
			AFERAGE	ļu.	314.1	18.4		316.1	-0.00	164.9	0.00		
			MAX S TRUE	<b>#</b>	316.46	116.46 105.4345		316.2	6.6	165.5	9.34		
				<b>=</b>	315.57	315.57 162.1276		315.6	-0.05	103.8	-1.08		

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¥ 3	EDPERINENT AMALTS IS	<b>3</b>	LISIS	<b>1</b>		Ė	42544	19 68847		95-Sep-19			
•	}		İ			į				20101			
						BOLLE TERS							
	FACTOR		_	FACTOR		1MB4C11846	. 92						
	•	-	<b>.</b>	-	FLOR TIRE			FLOR	1 (ME	2	Pu!		-
		TE ST	LENE	IENE IENE	RSE I	AESALT RESULT	FACTOR	EFFECT	PERCENT	EFFECT	PERCENT	IMPACT 1045	SAMMES
<b>-</b>	<b>-</b>	-	-		14.67	18.8	=	147.4	9.43	11.1	4.42	452	35
~ (	-	~	~	~	151.32	7.742	4.2	14.5	-4.29	7.5	-0.20	36)	30.
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Vermina Co.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

COST BENEFIT ANALYSIS REPORT TI PROGRAM

TYPE PROPOSAL OUICK FIX FOCUS STUDY

CONTROL NO. 87-037F

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DATE 05/ NOUN "CHARTAL SUSSESTION ALC OC DATE 02 RCC MTACA ITEM NO.

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PROPOSED METHOD

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BENEFIT OF CHANGE

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PRODUCTIVITY IMPROVEMENT SUMMARY

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# COST BENEFIT . AI CULATIONS

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Congreti CONTROL NO. 89-1018F 74050 27564 Jogunn 60500 TYPE PROPOSAL :/c~15 a/c X FOCUS STUDY MAT PCA area. □ QUICK FIX 164 Souctal Say 2 NOCE 55.70 1000 dresent □ OTHER 4000 Fa. Tures. and implemented 4000 16050 fa, "Inte failures as 1,2/0 for Hese Parts drown manutae turris neisture immense, abnormal Many especially if incorporated appropriate 9 **COST BENEFIT ANALYSIS REPORT** PRODUCTIVITY IMPROVEMENT SUMMARY

SER, JES PROGRAM

COST BENE. C .CULATIONS

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12115 CONTROL NO. 8-1-1/4F ACC S Sa. r W.Y.1.294537 TYPE PROPOSAL Darticular The Focus STUDY MATPCM 0 □ QUICK FIX 1501115 involving other □ OTHER 000 イんの Spec. 1. rc. 114 24.0 900 OFFECTIVE d L 101 response 20 operation times MATPCA from epertions Schoduler Opraf. 275 moulted 0100 Lackship 192057 **COST BENEFIT ANALYSIS REPORT** H 24,0/10/ PINC PREKERS 210 Sout From backshop 910 deman TI PROGRAM delivery schedules 110 סננפ נ 00 other 210001100 2.54000 4Ddates , fens Should backshop 2000,00 Ö condetel PRODUCTIVITY IMPROVEMENT SUMMARY 2002 010 and 26 10050 Office tively TECHNOL GY INSERTION ENGINEERING 5 caeration anolusis of Yie. rov.spo 916 3 000 : 10 1 4060 5436. inventory MUSCL 1.0.7 These delens RCC MATPCA ITEM NO. BENEFIT OF CHANGE PROPOSED METHOD 7 DATE 5 **CURRENT METHOD** book MATPEW 17 02 7 SERVICES PROGRAM Oxisting 7,00 NOUN GENERA dolar Scto.100 c + 101 1/5 00 would Deres 2005 000 70.00 000 ני יני زر 5007

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COST BENL I LCULATIONS

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OCD METHOD	DESCRIPTION ME total			WOTES:	Y YANGO YANG	PELTA COST 12 NO. SCHEDULE	IMPLEMENTATION COSTS	DESCRIPTION LABOR MATE				

TECHN 3Y INSERTION ENGINEERING CO	CONTROL NO. 3 . 16/
TI PI COST BENEFIT	TYPE PROPOSAL  QUICK FIX  DEFOCUS STUDY
- General	п отнея
many of the itens worked in this ACC have ATV or pot	Aotting compound
used to anchor internal components as well as provide insu	
moterials are tedious to remove, requiring a great duel or	of skilled technicias
PROPOSED METHOD	
A study should be performed to determine whether Formed	source housings
sheets could be subsituted for the presently	JeH.
1150, the use of phenolis blocks torned to hold components	in place should be
204/22CV.	
BENEFIT OF CHANGE	
A great deal of kine and offert could be reduced on	+k tarsekal
(ca) , tems it	More CFFective
use of resources and skilled technicinas would eccut.	
PRODUCTIVITY IMPROVEMENT SUMMARY	
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COST BENL . C. LCULATIONS

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CONTROL NO. \$\(\frac{2}{2}\) - \(\frac{2}{2}\)/- TYPE PROPOSAL  TYPE PROPOSAL  QUICK FIX  Procus Study  Are focus study  Are focus study  Are focus study	Many of Hese tools Dational Egonomie - Hunga Factors	designs would increase	is reent years pertaining	(See attacked do to)	
SERVICES PROGRAM  SERVICES PROGRAM  TI PROGRAM  COST BENEFIT ANALYSIS REPORT  RCC MAT PCA ITEM NO.  NOUN CANEEL SUSPECTION - ALC COST BENEFIT ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT  PLUI ANALYSIS REPORT	Gondonents Overhaul ACC (MATPEA). to presently recommended Occup	nt of mny of the presently next by decreasing hatisue and	F CHANGE  # eleo   of information  # Act incorrectly  # Act incorrectl	Sundrane and Mocculling Tendonitis have been clearly elemonstrated. There probled to Costily corrected by scleeting of the proper tool designs (See attacked to the proper tool designs (See attacked to the ).	

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AICIOC 321 CONTROL NO. 87-458F 57500 TYPE PROPOSAL X FOCUS STUDY moisture □ QUICK FIX D OTHER CODO FCC ۲ dessicant #15-0,000 compenent 527.20 **COST BENEFIT ANALYSIS REPORT** OTO 7. . 7 puir Parker inadepunt 18mac contras raduce TI PROGRAM 9 1000 We= 1 mo.'sture PRODUCTIVITY IMPROVEMENT SUMMARY heve 245.60 TECHNOLUGY INSERTION ENGINEERING technicians components CABC. 18:0 4/14 DATE 5-16/89 used NOUN GENORE/ SUSSMERI'S MATAL ITEM NO. 1/1.5 BENEFIT OF CHANGE PROPOSED METHOD Dicsently much lower **CURRENT METHOD** SERVICES PROGRAM Individual 26 me 500 20000 Cesealle - XACSUCE. 00 worked 116 ALC

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CONTROL NO. 6. . SAF TYPE PROPOSAL C.De. 1.c. 6/0 A FOCUS STUDY Cepa, r 0 OUICK FIX 2700 □ OTHER\_ 454ª //4 W. 74 authorized, sounss of 412 75. , Yen they can is not carded repairable PWIL Garker that COST BENEFIT ANALYSIS REPORT rec Sica. Ficant. 070 # 16 control box React costs been 4 TI PROGRAM 40 xhis tosk made COlacoment technicians has not 10003-350 PRODUCTIVITY IMPROVEMENT SUMMARY cost analysis Robectment of Cach component TECHN. GY INSERTION ENGINEERING CAL'S FLAG ITEM NO. 35//3A that 0550 250 DATE 5/15/85 1,000 Rox the compount thouseh coart analities Kelay **BENEFIT OF CHANGE** This amolities PROPOSED METHOD overhaul **CURRENT METHOD** SERVICES PROGRAM Techn Eigne NOON Control GUEN ACC MATPCA 5 Standard re pa.'r 4/4/2 ALC 4.76

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LCULATIONS COST BENEI

15C-20131A TOTAL COST TOTAL SAVIGS ENTENDED SITA COST O. M. **NEW METHOD** SUMMARY S YR PROJECTION ANNUAL IMPLEMENTATION COSTS EXTENDED SAVIKS **NET SAVINGS** DESCRIPTION GROSS SAVINGS DELTA COST NOTES: TOTAL KON PART TOTAL COST 1" YEAR SAWIGS TOTAL COST IMPLEMENTATION COSTS O.H. RATE PAUT COST O. R. OLD METIIOD EAT 12 MO, SCHEBULE COST AUBITAL SAYEGS DESCRIPTION DESCRIPTION DELTA COST NOTES:

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05/2 CONTROL NO. 87-06/F TYPE PROPOSAL A FOCUS STUDY 140 120 Derotive □ QUICK FIX SAPCIE approximately O OTHER 800-00 Bendix Compound hous. 'ne cost acsuited housing PHI GIROL 200/20 Color 0) ze/ **COST BENEFIT ANALYSIS REPORT** from 10/1/25 97 into the { 47avc. 1661P benef.'t TI PROGRAM 160 re placed siven. -05+ 4500 Compound 125th 1100 houseing assembly must be 255P-66 PRODUCTIVITY IMPROVEMENT SUMMARY asttins TECHNOLOGY INSERTION ENGINEERING Sw. Fch the switch NOUN Auto. Isa: +: sa Actuator Ser. Fch worked RCC MATRA ITEM NO. 357/11. DATE 5-11/65 redort if the The 1000 Com Bound BENEFIT OF CHANGE PROPOSED METHOD **CURRENT METHOD** Technicians SERVICES PROGRAM Ralace 10/ 9550-6/21 780 72 the entire 45 staked Presently Iroduces 2014,00 ALC O 1200 00 00

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NET SAVINGS								
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**TECHNOLOGY INSERTION ENGINEERING** SERVICES PROGRAM

**COST BENEFIT ANALYSIS REPORT** TI PROGRAM

RCC CMT A ITEM NO. 342574 DATE 5/25/89 Flowne ter ALC OC NOON

4/2 PHICKEL 120

CONTROL NO. 87-062F TYPE PROPOSAL A FOCUS STUDY □ QUICK FIX OTHER

6 51,000 COST circuit boards deta: Yed Doctornia 10t where cado ble of 45.23 are man hours 240 boards Doctolmod 12/16:11.75 technicians are 1,000,1 1200 Last internal Sharld Denetit 40 PROPOSED METHOD 460 Focus study **CURRENT METHOD** althoush 186.101 redlecoment 5054 Presently 46 7.500 15.

de. 2. -S610102 inslude beach: 13 **BENEFIT OF CHANGE** Poss. 61e

a 550m 6/L

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subsequent 3.3 lower overhaul costs other critical areas. utilized in

PRODUCTIVITY IMPROVEMENT SUMMARY

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TECH. 3Y INSERTION ENGINEERING SERVI PROGRAM

### COST BENEFIT CALCULATIONS

NEW METHOD	0.H	PART NA.						NOTES: TOTAL COST	EXTRIDED SAVINGS		DELTA COST TOTAL SAVINGS	VOLUMINO	ANNUAL ENTENDED	SAVINGS	IMPLEMENTATION		NET SAVINGS \$	
								TOTAL CO.			t" YEAR SAINGS		TOTAL					TOTAL COST
	100		-							1		N COSTS	O.H. RAYE					
OLD METHOD	N   N   N   N   N   N   N   N   N   N										EDULE	IMPLEMENTATION	TAM					
LD MI											12 MO. SCHEBULE	MPLEM	LABOR		_			
)	DESCRIPTION				•			NOTER	AMENAL BANGGO		META COST		DESCRIPTION					

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

COST BENEFIT ANALYSIS REPORT

**BOB BUTTRY** 

13 JUN 89

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DATE 13

INSPECTION

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RRB-QF7	
CONTROL NO.	

© COCUS STUDY

O OTHER

CUMPERT METHOD : QDR'S ARE WRITTEN DESCRIBING KNOWN DISCREPANCIES ON PARTS IN STORAGE. THE STORE'S MANAGER. DECIDES ON HIS OWN INITIATIVE IF A PART SO DESCRIBED AS POTENTIALLY DISCREPANT WILL OR WILL NOT BE INSPECTED THIS AFFECTS (SCREENED) FOR THE NOTED QOR DISCREPANCY PRIOR TO RELEASING THESE PARTS FROM THE STORAGE AREA. PRODUCTIVITY AS BAD PARTS ARE FIRST DISCOVERED ON THE PRODUCTION FLOOR.

CRITERIA RELATING TO THE NUMBER OF PARTS OR THE NUMBER OF TIMES A PART IS FOUND TO BE DISCREPANT ON THE PRODUCTION PROPOSED METHOD: REQUIRE ALL PARTS IN STORES TO BE SCREENED FOR ODR NOTED DISCREPANCIES ACCORDING TO A SET FLOOR.

PRODUCTIVITY WILL NOT BE IMPACTED IF DISCREPANT PARTS ARE REMOVED FROM STORES BEFORE SENDING THESE SCREENED PARTS TO THE PRODUCTION FLOOR. ENERT OF CHANGE

DOWNTIME AND FLOWTIME WILL BE REDUCED BY REMOVING DISCREPANT PARTS FROM SUSPECT LOTS OF PARTS IN STORAGE PRIOR TO SENDING THESE PARTS INTO PRODUCTION. PRODUCTIVITY IMPROVEMENT SUMMARY:

### REQUESTED COST DATA FOR RRB-QF7

### Cost Savings:

Present Condition Cost For the Last 12 Months:
Rework costs associated with repairing supplier parts received from stores and delivered to the production RCC when the noted reason for repair is already documented on a QDR = \$
Scrap costs for parts associated for the above = \$
Return to supplier (stores) costs for parts associated with the above = \$
Labor costs associated with the above parts = \$
Proposed Implementation Cost:
Costs either to return or to screen all parts in stores identified as discrepant on a QDR = \$
Annual Cost Savings (First Year):
[Present Condition Cost] - [Proposed Implementation Cost] = \$

THE PROPERTY ENCINEERING	CONTROL NO. RRB-0F4
SENICES PROGRAM	TYPE PROPOGAL
COST BEN	G OUCK FIX
¥106	□ FOCUS STUDY
FICE ALL STEEM NO.	OTHER
	INSTRUCTIONS. THE TECH
COMMENSATION INVIDENTIFICATION OF THE COPIES THAT THEY KEEP HANDY AT THEIR WORK STATIONS.	ORK STATIONS. THESE COPIES
	USE WHEN "MORD OF MOUTH"
INFORMS THEM THAT A TECH ORDER REVISION HAS BEEN ISSUED.	
BEACHAGE METHOD. REPLACE ALL TECH ORDER MANUALS WITH PAPERLESS, COMPUTER GENERATED, ELECTRONICALLY UPDATED.	ED, ELECTRONICALLY UPDATED.
ERS. 10C	TO ALL MECHANICS. KEEP
THE TECH ORDERS UPDATED SO THAT THE MECHANICS WILL ALWAYS HAVE ACCESS TO THE MOST CURRENT PROCEDURES.	ENT PROCEDURES.
PROCEDURE	RATION AND PROCEDURE.
(2) TECH ORDER MANUALS WILL NOT REQUIRE PERIODIC, TIME CONSUMING UPDATING. (3) TECH O	(3) TECH ORDER UPDATES WILL OCCUR
	CO MANIJA S CAN BE DETDATNED
3	I NOT HAVE TO BE REDONE.
FOR OTHER DUTIES. (2) PARTS THAT FORMERLY WERE REPAIRED TO DOI-OF-DATE PROCEDURES MILE TO THE TOTAL PARTY.	
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### REQUESTED COST DATA FOR RRB-QF4

OSL	<u>24 A 1 III</u>	42:	

Present Condition Cost For the Last 12 Months:
Rework and scrap costs associated with mechanics repairing parts to unauthorized/uncontrolled copies of technical orders = \$
Cost to print, distribute and incorporate all changes to the technical orders = \$
Proposed Implementation Cost:
Cost involved to install CRTs on the production floor so that all mechanics will have convenient access to a CRT = \$
The special data processing cost required to initiate/implement this system = \$
Annual Cost Savings (First Year):
[Present Condition Cost] - [Proposed Implementation Cost] = \$

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**DATE** 19 JUN 89 **COUNTINUE PART IDENTIFICATION** TEM NO. COMPAND S ALL

**COST BENEFIT ANALYSIS REPORT** TI PROGRAM

RRB-QF2 TYPE PROPOSAL CONTROL NO.

□ FOCUS STUDY (A) QUICK FIX

**BOB BUTTRY** 

OTHER 0

IN ORDER TO BE STAGED FOR INSTALLATION. IF, DURING INSTALLATION, A PART IS FOUND TO BE DISCREPANT, A QDR MAY NOT CODE, AND DATE OF MANUFACTURE. THIS IDENTIFICATION MAY BE LOST IF THE PART IS REMOVED FROM ITS OUTER PACKAGING CURRENT METHOD: USUALLY, ONLY THE OUTER PACKAGING OF NEW PARTS HAS THE SUPPLIER'S CONTRACT NUMBER, VENDOR RESULT IN SUPPLIER CORRECTIVE ACTION DUE TO THE LACK OF ANY OF THIS I.D. INFORMATION ON THE QDR.

THE P.O. SHOULD ALSO STIPULATE THAT THE PART(S) MAY BE RETURNED MANDATE A GENERAL CONTRACT P.O. REQUIREMENT THAT THE ABOVE 3 PIECES OF I.D. BE AFFIXED TO EACH PART BY THE SUPPLIER PER AN ACCEPTABLE METHOD. PROPOSED METHOD:

TO THE SUPPLIER WHENEVER THE OUTER PACKAGE IS OPENED AND THE NOTED I.D. INFORMATION IS MISSING.

(1) SUPPLIERS WILL BE REQUIRED TO TAKE CORRECTIVE ACTION FOR EVERY SUPPLIER RELATED QDR. BENEFIT OF CHANGE:

(3) NO PARTS STILL UNDER WARRANTY WILL BE (2) ALL SUPPLIER RELATED QDR'S WILL BE ANSWERED IN A TIMELY MANNER. SCRAPPED OR REPAIRED AT THE EXPENSE OF THE ALC. PRODUCTIVITY IMPROVEMENT SUMMARY: THERE WILL BE LESS DOWNTIME FROM RECURRING DISCREPANCIES FOR NEW PARTS AS SUPPLIERS ARE REQUIRED TO ACCEPT THE RESPONSIBILITY FOR CORRECTIVE ACTION ON QDR'S WITH PROPERLY DOCUMENTED

PART IDENTIFICATION.

### REQUESTED COST DATA FOR RRB-QF2

Cost Savir	ng:	\$:
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Co	st Improvement Data:
	Present Condition Cost For the Last 12 Months:
	Cost to replace all new purchased parts that were scrapped at the expense of the ALC due to the lack of necessary supplier I.D. at installation = \$
	Cost to repair all new purchased parts at the expense of the ALC due to the lack of necessary supplier I.D. at installation = \$
	Proposed Implementation Cost:
	Cost incurred by ALC purchasing office to insert the noted P.O. requirement (ref. "Proposed Method," page 1) ** \$
	Estimated additional annual cost by all ALC new parts suppliers to implement the noted I.D. requirement as specified (ref. "Proposed Method," page 1) = \$
	Annual Cost Savings (First Year):
	[Present Condition Cost] - [Proposed Implementation Cost] =

F	TECHNOLOGY INSERTION ENGINEERING	CONTROL NO. RRB-QF1
ð	SERVICES PROGRAM  TI PROGRAM  COST BENEFIT ANALYSIS REPORT	TYPE PROPOSAL
3	WIDE DATE 19 JUN 89	G GUICK FIX
企 克	RCC ALL ITEM NO. NOUN NEW PART WARRANTIES	
_	CURRENT METHOD : SUPPLY RECEIVES AND STORES NEW SUPPLIER PARTS FOR SUBSEQUENT DISTRIBUTION AND USAGE BY ALC	IBUTION AND USAGE BY ALC
سلسا	SHOPS. NO STOCK ROTATION METHOD IS BEING USED TO ASSURE A "FIRST IN - FIRST OUT" DISTRIBUTION OF THESE PARTS. DARTS HAVE A MARRANTY THAT IS VALID FOR A SPECIFIED PERIOD OF TIME. THIS WARRANTY BECOMES VOID WHEN DISCREPA	- FIRST OUT" DISTRIBUTION OF THESE PARTS. NEW THIS WARRANTY BECOMES VOID WHEN DISCREPANT
لسل	NEW PARTS ARE NOT DISCOVERED WITHIN THIS TIME PERIOD.	
<b></b> -	PROPOSED METHOD: TO AVOID THE ABOVE, SUPPLY SHOULD DATE STAMP EVERY PART, OR THE OUTER PACKAGE OF EVERY	OUTER PACKAGE OF EVERY
ـــــــــــــــــــــــــــــــــــــ	. SUPPLY	THE OLDEST DATE STAMPED
4	DUCTION	
سلسا 4 اوو		
744	BENEFIT OF CHANGE: (1) SUPPLIERS OF DISCREPANT PARTS UNDER WARRANTY WILL BE REQUIRED TO REPLACE OR REPAIR	ED TO REPLACE OR REPAIR
1	THEM AT NO COST TO THE ALC. (2) THE DISCOVERY OF NUMEROUS DISCREPANT PARTS WITHIN A CONTRACT LOT USUALLY ALLOWS	TRACT LOT USUALLY ALLOWS
T	THE ALC TO RETURN THAT ENTIRE LOT TO THE SUPPLIER FOR PARTS SCREENING AND SUBSEQUENT REPLACEMENT OR REPAIR AT THE	LACEMENT OR REPAIR AT THE
	SUPPLIER'S EXPENSE. (3) SUPPLIER CORRECTIVE ACTION BECOMES MORE TIMELY, RESPONSIVE, AND EFFECTIVE. (4) UNRELIABLE	EFFECTIVE. (4) UNRELIABLE
	SUPPLIERS ARE ELIMINATED EARLY-UM:	
	PRODUCTIVITY IMPROVEMENT SUMMARY: CYCLE AND FLOW TIMES BECOME REDUCED WHEN HE	REDUCED WHEN MECHANICS NO LONGER MUST
	REPAIR NEW PARTS PRIOR TO USING THEM.	
		000/201

r In Accordance with the uppears.

### REQUESTED COST DATA FOR RRB-QF1

Cost Saving	<u>s:</u>
Present	Condition Cost For the Last 12 Months:
(A)	Cost of scrapping all new purchased parts at the expense of the ALC due to expired warranties = \$
(B)	Cost of repairing all new purchased parts at the expense of the ALC due to expired warranties = \$
Propose	i Implementation Cost:
Labor the	r costs involved to date stamp the new purchased parts and rotate oldest stock forward during the storage of new parts = \$
Annua? (	Cost Savings (First Year):
[Pres	sent Condition Cost] - [Proposed Implementation Cost] = \$

TECHNOL . INSERTION ENGINEERING SERVICES PROGRAM

COST BENEFIT BENEFIT COST BENEF	
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FECHNOL. INSERTION ENGINEERING	CONTROL NO. 8 1- 188
TIPROGRAM	TYPE PROPOSAL
COST BENEFIT ANALYSIS REPORT  ALC $OC$ DATE $OS//5/65$	A QUICK FIX
ACC MATREA ITEM NO. 97/33A	□ FOCUS STUDY
ر⁄د .	□ отнея
CURRENT METHOD	
most of those items have one nort blocked off.	They are west
Ly the oft was 10 soson	
chauled, the tem is been in	1 h. tooling
the fuel transfer yest st	
PROPOSED METHOD	

the item is no lonser used in its orison and the third port (fuel) is blocked off by ison, the required testing procedure should be de	dociesal	The Ourchasing		
the item is no lonser used in end the third port (fuel) is blocked is shown shown shows the resting procedure shown shown	oriconall.	6,	de	
the "1cm"; sold the 16	54, ",	blocked of	c should i	
the "1cm"; sold the 16	ec used	(fuel) is	or procedur	
the "tem "s and the 1694	no lons	ied port	ired testi	
ce the	Them is	+4c +4	the legy.	
19 6 2	L'nee vie	manner, and	gonization,	

BENEFIT OF CHANGE
By deleting the unrecessary test turnational on this item would
be shorkened by one hour for each individual s-way solvet valve, This
would free skilled technicians for other duties, free testing equipment
for other uses, and otherwise reduce operating expenses,

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PRODUCTIVITY IMPROVEMENT SUMMARY			,

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LSC-20131A to check water CONTROL NO. \$9-01) A on the existing subsequently reducing the evaporation TYPE PROPOSAL a ppeal ☐ FOCUS STUDY Showld Q OUICK FIX O OTHER 070 Pc. 14 reduce 292 to-Mereture COVER operation routinely oversure Nitrogen 1000560 ~ 15-20 Minutes an insulated sien! Ficently 2 occulting one minute # 070 glacor! Dersonel evadorating COST BENEFIT ANALYSIS REPORT Chree shile 4 on work logo TI PROGRAM 1001 be cahanced to Shall pt from water to the heet 000/60 installation 1001:00 o e Kak trst Must maintain required level in coct noted Acal the b) now PRODUCTIVITY IMPROVEMENT SUMMARY bc + 4 water 144.7 for the Check 2071 the TECHNOLOGY INSERTION ENGINEERING described RCC 447 RA ITEM NO. 38669. oraduc fivity 1.00 water NOUN Igaition Excitet LEGK that 140 DATE OS 105, reguired inexpans.'ve After isa. tion excitel ARVEAT Suggested bathi BENEFIT OF CHANGE blueld a bove temporature 4524 PROPOSED METHOD **CURRENT METHOD** SERVICES PROGRAM avea the aperator £ ... C tempetature is Irakaçe. Derlora the 160 10 10 + : UP 14 heat ing Jafer ALC

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SE. PRC IAM

COST BENL. 11 .LCULATIONS

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MOTES:							
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DESCRIPTION							SUMMARY
	COST	MAT	O.H. RATE			TOTAL COST	ANNUAL ENTENDED
							68085
							SAVINGS
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							NET SAVINGS \$ \$
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TECHNOL : INSERTION ENGINEERING SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

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ALC	RCC /	NOON

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QUICK FIX

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PROPOSED METHOD

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**BENEFIT OF CHANGE** 

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PRODUCTIVITY IMPROVEMENT SUMMARY

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SERV. PRG JAM

# COST BENEFIT CALCULATIONS

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TECHNOLOGINSERTION ENGINEERING SERVICES PROGRAM

**COST BENEFIT ANALYSIS REPORT** TI PROGRAM

DATE 5/10/89

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ITEM NO.

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TYPE PROPOSAL

A QUICK FIX

☐ FOCUS STUDY ☐ OTHER

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CURRENT METHOD	The A3 module of this item requires approximately 9.0 hours to	God Ceplace. T	through testing before istrical specifications and toleknoes must be determine	PROPOSED METHOD	,	7407	Il it is the wender they have tested within I'm its at
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# 112 tast tod that all Theretur **BENEFIT OF CHANGE**

Turnstouse Carting resources Lastellation time 72000 700 500ci F. cations Nocedures SUMOY rod PRODUCTIVITY IMPROVEMENT SUMMARY 1/c/eby reducer Technitisns Dayale 100

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SER. PRC JAM

COST BENE: LCULATIONS

	OLD METHOD	TIOL					
DESCRIPTION		COST	20		ř		NEW METHOD
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NOTES:				TOTA	TOTAL COET		
AMBIAL SAVINGS					3		HOIES:
		/					EXTRIDED SAWIGS
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ORITA COST	12 IAO. SCHEDULE	FOULE		1- YEAR	1" YEAR SAVIJGS	ı	DELTA COST S YR PROJECTION TOTAL SAVIGS
	IMPI EMENTATION COCTO	MTATIC	100				
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DESCRIPTION	LABOR	TLYM	O.H.			TOTAL	ARY
			HAIR		1	1505	ANNUAL ENTENDED
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							NET SAVINGS \$ \$
				TOT/	TOTAL COST		
							150,20114

applicable to overhout histories skilled technicians Overheal (MATROC. 108411.05 TYPE PROPOSAL replacement ☐ FOCUS STUDY inspection CONTROL NO. GSSune on this exciter, invarior in dangee A QUICK FIX □ OTHER turnaround includes arc,'25 ifen and 169,5000 610 selective return E S diagnostic test resources 40 a fe guicker MATROC Mars 00 due A COST BENEFIT ANALYSIS REPORT Pa. 1/400 OIO PHIL Arker two to three 0.74.00 ď 9 TI PROGRAM 4 Metoluce utilization tarsetod ď isaition exciter ن: ف toc would 4 Ce 10 informal transformer unit Proce5500 645925 HOU act sot PRODUCTIVITY IMPROVEMENT SUMMARY change test TECHNOLUGY INSERTION ENGINEERING 21202 Technicians Coutine franstorner The benefits of this inventor opola hine 50% NOUN Zaition Excite ACC MAT PCA ITEM NO. OC DATE 5/ Dy designating BENEFIT OF CHANGE PROPOSED METHOD Y **CURRENT METHOD** Q SERVICES PROGRAM 502 hours. recluced Roort interne Z resenth +40 return · fen that and

LSC 20131A

SER. PRC JAM

COST BENL .1 . CULATIONS

NEW METUDE		DESCRIPTION SIGN COST O. H. HR COST								NOTES:	1	EXITABLE SAMIKES	DELTA COST SYR PROJECTION TOTAL SAVIGS		SUMMARY	ANNUAL ENTENDED	SAVINGS	COSTS		NEI SAVINGS S
	MINI	TALA PART								TOTAL COST			1" YEAR SAVINGS			TOTAL				_
	0.K	#	1				+	-						IMPLEMENTATION COSTS	-	RATE				_
THOD	Λ	-				1	1	1					Duce	NTATION						
OLD METHOD		-											12 MO. SCHEDULE	APLEME		COST				
	DESCRIPTION									MOTES;	AURIAL SAYINGS		DELIACOST	N	DESCRIPTION					

TECHNOLOW INSERTION ENGINEERING SERVICES PROGRAM

ALC 0< DATE 5/16/89

RCC 202, ITEM NO. 502,

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COST BENE

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HOGHAN	ANALYSIS	
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CONTROL NO. 87- , J. A. TYPE PROPOSAL

X QUICK FIX

☐ FOCUS STUDY

□ OTHER\_

	C1 # 120	
CURRENT METHOD		
This ignition excited uses a potting compound to anchor the internal	nd to anchor	the interact
composents as well as act as an insulator for them, This company must	or for them,	This company must
be chigged out For overband purposer.		

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	as in the case of other related ignition	
	other	
	af.	
	CASE	
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	10000	
PROPOSED METHOD	ATV.	
SED M	Je 57.	
PROPC	Use of	

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	BENEFIT OF CHANGE	

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Sealant	aking ber	700
RTU	mechaul, m	وع في مررس
or the	200 50,3	rehnici
7kr use	1.moval du	and stilled

Limoval ducing everhaul, making better use of present resources and
and stilled technician's time
PRODUCTIVITY IMPROVEMENT SUMMARY

TECH: LOGY INSERTION ENGINEERING SERVI 'ROGRAM

COST BENEFIT CALCULATIONS

DESCRIPTION   A		OLD METHOD	THOD				NEW METHOD
NET SAVINGS   STATE NOTAL COST   NOTE	DESCRIPTION		\ <b>#</b>			TI DO	DESCRIPTION EST COST ON
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NOTE   NOTE						-	
NOTES:   N							
TOTAL COST   NOTES:   TOTAL COST   NOTES:							
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NOTES:   N							
IMPLEMENTATION COSTS  LANOR MATL OM COST  COST RATE COST  COST SAVINGS  SUMMARY  ANNUAL ENTENDED  GROSS  SAVING	- 1				TOTAL C	OST	
IMPLEMENTATION COSTS  LABOR MATL OR FAULE  COST FAULUS SAVINGS  SUMMARY  ANNUAL ENTENDED  GROSS  SAVINGS  SAVIN							
IMPLEMENTATION COSTS  LABOR MATL OM. TOTAL SAWNS  COST ANNUAL ENTENDED  GROSS SAVINGS	<u> </u>						
IMPLEMENTATION COSTS		17 MC 304	)		1-YEAR SA	MNGS	S YR PROJECTION
LAMOR MATL OR. TOTAL COST COST COST COST COST COST COST COST	M	PLEME	NTATIC	SOO NO	73		
GROSS SAVINGS SAVINGS IMPLEMENTATION COSTS NET SAVINGS S	DESCRIPTION	LABOR	IAT	O.N. RATE		TOTAL	- E
SAVINGS \$ \$ \$ COSTS IMPLEMENTATION COSTS							
COSTS							•
COSTS							IMPLEMENTATION
NET SAVINGS \$							
						-	
					TOTAL	1SO:	

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TECHNOLÖĞY INSERTION ENGINEERING SERVICES PROGRAM

**COST BENEFIT ANALYSIS REPORT** TI PROGRAM

	1-05%	SAL
0	IL NO. 2	TYPE PROPOSAI
•	CONTRO	λ1

A QUICK FIX

☐ FOCUS STUDY

C OTHER

**CURRENT METHOD** 

NOUN Zeartion Exc. tec.

ALC DC DATE S/

punc Parker

on this exciter, and Overhaul (MATROC, includes replacement due to atcing damage selective *test* 12/16 onostic R. 1/4.00 1.44.05 tarseted nertara transformer unit Coutine 506 Techaicians internal さらさ resenth · fem.

PROPOSED METHOD

Stars interacts Capplicable to overland theightic to return to inventive in one to inspection of 95542E 1.4.4 for 1.54a1 MATAOL HEA two to three ignition exciter A T Processou bay sassus sot test of all itens functions BENEFIT OF CHANGE derigno him 60 in: 60 hours 50% 'aterne

skilled technicians quicker tarnaround resources and would include util. 2a tion rete/ The benefits of this change eperating Losts inventor. to A.F. rechiced refura and

PRODUCTIVITY IMPROVEMENT SUMMARY

SE, PRO JAM

COST BEN IN LCULATIONS

. . . . . . .

	OLD METHOD	TIOD					·
DESCRIPTION	1500	$\Lambda$	9.K		2	1	NEW METHOD
	2	<u> </u>	¥		Į.	LE SE	1101
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MOJES:				TOTAL	TOTAL COST		NOTES:
AMENAL SAVEIGS						Ì	
							Extraoged Sawings
MELIA COST	12 MO. SCHEDULE	DUE		1" YEAR SAYRICS	AWAGS		DELTA COST SYR PROJECTION TOTAL SAVINGS
3	MPI EMENTATION COCT	MIATO	300				
				<u>0</u>			
DESCRIPTION	COST	MAT	O.H.			TOTAL	SUMMARY
							SAVINGS
							COSTS
					T		
					<del> </del>		NET SAVINGS S
				TOTAL	TOTAL COST		
							LSC 20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES BROGRAM	CONTROL NO. RRB-FS2
TI PROGRAM COST RENEFIT ANALYSIS REPORT	TYPE PROPOSAL
3 JUN 89	O QUICK FIX
RCC ALL ITEM NO.	E FOCUS STUDY
NOUN SCRAP	O OTHER
CURRENT METHOD: PRODUCTION OPERATIONS GENERATE SCRAP THROUGH A VARIETY OF CAUSES.	THIS SCRAP IS ORDINARILY
REMOVED FROM THE RCC FOR DISPOSAL, ALONG WITH THE ACCOMPANYING WCD'S.	
PROPOSED METHOD. FACH RC SHOULD MAINTAIN A SCRAP LOGROOK THAT LISTS FACH DART AS	TT 18 CCDADDED AND THE
1	-
BENEFIT OF CHANGE: A PERIODIC REVIEW OF AN RCC'S SCRAP I OGROOK COIN DIRE INSENTINE WOW TO BENINE	TERMINE UNI TO BENINE
EXCESSIVE SCRAP BY IMPLEMENTING METHODS TO ELIMINATE, OR REDUCE, THE REPETATIVE CAUSES FOR SCRAPPING PARTS	OR SCRAPPING PARTS
PRODUCTIVITY MAPROVEMENT SUMMARY: PRODUCTIVITY IMPROVEMENT IS DIRECTLY RELATED TO REDUCING SCRAP BY	ED TO REDUCING SCRAP BY
CORRECLTY REPAIRING A PART OVER THE SAME TIME PERIOD THAT A PART PREVIOUSLY WAS INCORRECTLY REPAIRED.	TLY REPAIRED. ALSO,
MATERIAL WASTE IS REDUCED BY NOT HAVING TO DISPOSE OF THE SCRAPPED PART. ALSO SAVET COST OF PURCHASIANE	COST OF PURCHASIME A
SLAND NEW REPLACEMENT PLONT.	
	Western

## REQUESTED COST DATA FOR RRB-FS2

Onecent Condition	cost	for	Last	12	Mont	hs	
-------------------	------	-----	------	----	------	----	--

Annual cost associated with maintaining a scrap logbook within each RCC. Each part scrapped must be identified, dated, and the reason for scrap indicated.

Cost	of	Log	pool	(s)	=	\$ 
Labor	r C	ost	for	Entries	=	\$ 

4-25-87:

ON ENTERING AREA (CA) MY FIRST OBSERVATION WAS THE ODER OF TRI-CHLORETHANE LISEDAS A DEGREASER. FROM PAST EXPERIANCE, I HAVE FOUND TRI-CHLOR TO BE A DIFICULT CHEMICAL TO WORK WITH-BIO.ACT IS A NATURAL DEGREASER THAT IS BIO DEGRADEABLE THATERIAL THAT WHEN CONTAMINATED, MAY BE DISPOSED OF BY INCENERATION TEST EQUIPMENT WAS SOMEWHAT ANTIQUATED BUT CENTRALLY LOCATED AND EASILY ACCESSABLE BY ALL TECHNICIANS LIGHTING WASE ADEQUATE AREA WAS CLEAN, AND COMPRABLE TO MOST FABRICATION FACILLITIES. THE TECHNICIANS SEEMED WELL TRAINED & QUITE COMPETANT FOR ASSIGNED

4-26-89

TASKS

PIOZZ

DBSERVED PHYSICAL MEASURING OF
CASTINGS & MACHINED PARTS. METHODS
USED WERE CONVENTIONAL MICROMETERS
& STANDARD INSPECTION INSTRUMENTS.
THE USE OF A SHALL "CORDAX" (COORDINANT
MEASURING) MACHINE WOULD ENHANCE
DIMENSIONAL CREDIBILITY.

4-27

OBSERVED EXCESSIVE, MOISTURE INDUCED,
PIOTS CONTAMINATION OF CASES, RESULTING IN
RECLEANING OF CASES ACCEAN ROOM
ENVIRONENT HOULD ELLIHINATE THIS
CONDITION. HUMIDITY & TEMPERATURE
CONTROL WOULD EN HANCE LONGIVITY
OF THE PRODUCT.

4-28

OBSERVED MULTI-STEP TESTING OF PRODUCT
PIOFY THIS OPERATION COULD BE IMPROVED
BY THEUSE OF A "FAULT FINDER" ACNC TEST
UNIT WITH A PRINT OUT. THIS WOULD
ALSO GIVE TRACEABILITY OF ALL REPAIRS
WITH A PERMINANT RECORD.

5-4-89 OBSERVED EXCESSIVE TRANSITTIME PCA TO PCD.

PIO \*5 REQUESTS THE TRANSFER OF ONE

5.5.89 ELECTRONIC TEST BENCH # OC 4929 &
OC 3609 WENT DOWN AT APPROX
10:00 HR5 & WAS OUT OF SERVICE
WITH APPROX. FIFTY COMPLETED UNITS
PIO\*7 AWAITING TEST. A"QUICK FIX" WOULD
BE TO PLACE FIBERGLASS FURNACE
FILTERS ON TOP OF LOUVERED
CABINATES, REDUCING THE AMOUNT
OF CONTAMINATION TO ELECTRONIC

PIDES TEST STAND \* OC 5507 THIS UNIT

PURCHASED AT COST APPROXE 1.3 MIL.

15 MARGINALY FUNCTIONAL (5%)

AND IS NOT COST EFFECTIVE

(1.0 MAN HRS TO TEST EXCITERS)

(PIO	*8 C	ONT.)			• : : :	• • •	• •
5	IMMON	15. TI	-IF 0	EM	HAS A	SIMPLE	TEST
3	TAND	THA	T CON	DUCT	THE	SIMPLE SAME	TESTS
1	IN JEI		11N. L	L.IT.H	4 PRIM	TOUT	FOR
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# ENG NOTES 5-3-89 MAT PLA PAGE 4

PIO	WHILE OF	BERVIN	G A TEST C	OPER, I CHECKE IBRATION ON	D
	•		TEST ITEMS	· · · · · ·	
				ZO SEPT 18	
	OC 395Z	ELECTE	ST BENCH	4-21-89	
	OC 3953		" "	7 APR 86	
	00 4929		11 - 1 - 1	L-7-86	
4				Y AT BREAKDE	
	YEARS	OF STA	M BLACKEN	D THE UNIT .	
	ON DA	ILY MAI	NT. REQUI	RE MENTS.	
	ACT M	ETHOD	SUGGEST	PLANNERS	
**************************************			\$ METHODS	S TO VERIF	<i>y</i>
		•	•	and the second s	

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tin<mark>a terrena de la capación de la capación de la composition della composition della composition della composition della composition della composition della composition della composition dell</mark>

FNG. NOTES. JACK CARTER PCN 42590 FLOW CHART DIO & OLS - REC & YERIFY DIG OUT EPOXY-FOAM - NOTE - EVRY EFFORT SHOULD BE MADE TO RELETE THIS OPER IT IS VERY LABOR INTENSIVE & NOT COST EFFECTIVE ... 030 MOVE TO TRICHLOR TANK FOR CLEANING 040 KISUALINSPECTION AT HORK BENCH OP 040 THRU IZO - ELECTRICAL TESTING DONE AT TEST STAND- IDENTIFY SUB STANDARD PARTS 380 REPAIR OR REPLACE PARTS AS REO'B. 390 REASSEMBLE ALL COMPONIAN PCN 37719A AUTOMATIC PILOT - 48 UNITS PER MO. NOTE: THIS OPER WILL BE PHASED OUT OVER THE NEXT TWO TO THREE YEARS- AREA. WAS WELL LIGHTED OPERATOR COMPETANT & WELL EQUIPMENT ADEQUATE TO THE PRODUCT REQUIRE MENTS ....

-,-

		_
DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
	(30053A)	
05/04/89	Interview performed with Wendel	MAINCA
	Hawkins, teschibed rework of combox	<del></del>
	assy. While not specifically noted	
	as an operation on the web, the	<del></del>
	requirement to disassemble (and all related	
	-perations) is determined by the result	
	of an initial diagnostic test of the	
	of an initial diagnostic test of the contex it. If the item checks out OK, the switch is replaced and aligned,	
	OK, the switch is replaced and aligned,	/
	and the unit is included and	
	retained for ise. Switch replacement,	
	adiustment, and cleaning procedures take	
7	adjustment, and cleaning procedures take ~ 20 minutes in perform All work is	
	done at technicisms beach, with	
	specialized testing equipment and zools	
	being checked out from a central tool bin	
<del></del>	located in the unit. If a disassembled	
	last is out at tolerance, it is replaced	
<del>                                     </del>	W new parts, Two main testers are	
1	used, and both are partable uniterally two	in unit
<del>   </del>	(1) Switch adjustment device (SA120)	/
<i> </i>	(2) Dial Indicated (DI)10)	
<del>                                     </del>		
<del></del>	Total time reported: 2.52 hopunit	
} <del>-</del>	THE THE THEOLOGY	
<del></del>	Note: Possibility of lower grade  Host technician "to perform initial  Host procedure, route tested items to	
<del>                                     </del>	fost technician to perform a trai	
<del>   </del>	TOUTE TESTED TOME TO	<del>/</del> -
	rework technician of inventory as	
	reguired.	
05-04-89		
P10 # 1	Suggest the creation of a primary initial	
	tester" of the cambox assy unit. This individual could be at a lower grade	
	individual could be at a lower stade	
l I	land and lac recharate contine the	
	ngit to the overhaul technician if required or serviceming the shorter refitting talk if the source of Quielsor	<u> </u>
ļ	or sorier ming the shorter cetiting talk	
ļ	if tost s Dx. Benefits: Quieker	· · · · · · · · · · · · · · · · · · ·
ļ	turniver and return to inventory, better I	
	utilization of skilled overhand techs,	

)ATE/P10 #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/05/89	Interview with Larry Ware (WG-10) on	MATPLA
/	Ignition Exciter (38669A) Tework. Unit require	• /
· _	several test procedures (see opp. profile).	<del>'</del>
\	After the initial election inspection.	
	and tostine, the unit is hand-carried	
\	to the machine shop (MAT PEM) or the	
1	mechanic for Lid removal. Note that only	
1	mae machine is normally designated isr	
	Mens task, and that the wait will insmally remain at MATPEM for 24 his until	
/	remain at MATPEM for 24 his until	
/	it returns to MATPEH. The unit is	· .
/	then disassembled inspected, and soveral	
i	then disassembled, inspected, and soveral liniernal seems are insect. Parts are	
!	removed and replaced as required.  After ressembly and testine, the  unit is hand-carried to the welding	
1	After rassembly and testine. The	
	unit is hand-corried to the welding	
i	shop (MATPIW) by the mechanic, and	
	shop (MATPIW) by the mechanic, and the lid's welded on. Time at MATPIW	
	15 ~ 24,16C.	•
·		
1	Note: It appears that rebuil cits are	
;	normally ordered (by regulation) only when	
,	units are received. This can cause up	
	to 2 day delay for Kit receival into	`
<u> </u>	unit. Technicians are ordering extra Kits	
	to avoid this.	```
/		
_/	Note: If the filter assy (opa 65) is	
	(sed, very long de lay ( ) due to	
<i>!</i>	beekshop ( ) turnaround,	
<u>:</u>		<i>;</i>
	Note: If items replaced with new	<u> </u>
1	enlacement items, then no requirement to lost unit for specific item function.	
\	a lost unit for specific item function.	
\	Technicians note kick rate of failure of	
\	10w items (suggest study of school reliability	
	Frew items:). Technicians are presently performin	<del>'</del>
<u> </u>	deds.	· · · · · · · · · · · · · · · · · · ·
	lite: water beth being adjusted down	
	o Account evaporation, Requires ~15-20	
<u></u>	elaboled to reach postinul heat	

Suggest to installation of a

lid on water both to reduce

evaporation while maintaining heat at operational

local.

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/8/69	Interview with Larry Ware on	MATPC4
	PC: 49711A. An initial test is	
	performed on this unit. If the	/
	tost is ok the unit is routed	7
	To inventory. It the unit fails	
	The property of the spring that is	\
	it is lowled to overhaul. There is a ~50% failure late.	<del></del>
	0 ~30% FE. 1618 18.18	<u> </u>
	1 1 7 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	<del></del>
	Note: It the nousing must be extended	
	remont to report turnes being product	<u> </u>
	Townson for sievent fumes being product	<u> </u>
	dution the welding opn, It should also be noted that Lie to the nature	
	also be noted that die to the nature	
	of this large capacitor assu, there	
	associated with this item. Time must	
	associated with this item. Time must	/
	be taken in discharging and disassemb	line !
	this unit,	7 1
	There are several testing procedures	,
	involved in the coordant of this	į
<del></del>	unit. It is also an involved process!	:
	to desergentle and repair the capacit	<u> </u>
	assembly. Much of the testing coup.	<del></del>
	is suldstod and prone to long orun	
	times, and in some cases midition testing must be performed due to inchequate or missing company.	
	testing must be performed due to	\
	inadequate of missing coupment.	
	<u> </u>	
	Nute that there are several cases	
	where inspections and/or tests can	<u> </u>
	must be performed as support work.	
	The Assell't Hareful pricts that evenific	ant
	Aima me the strat on any cope item	1
	in hokeled a metions	I I
5/2.54)	indicate that further machining or we'ding must be performed as suspirit work.  The possibility therefor exists that signific time may be spent on any one item in backshop operations.	
0 # 3	Suscestion that a detailed analysis be confirmed as to viability of new test equipment Igeneralized in nature) given decreasing demand of these items.	.,
ر	Justes 17 30 TRET & OFTOIRE WILLIAM	<del></del>
	be corrormed as to via or its of new	<del>/</del>
	test equipment igeneralized in intuity given	<del>/</del>
	decreasing demand of these items.	
1		<u>{</u>

DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
5/8/85	(continued) in 49711A.	MATPLA
1 (0-12/55)		7//// 21/
PTU = 4	from the remetacturer are displaying a lack tailure rate, mainly due to improper packing from the manufacturer	<del>                                     </del>
	Con de la faction de la Co	<del> /</del>
	Trom se resultation and displaying	<del> /</del>
<del></del>	a fact in tule 1800, mainly due -0	<del>- /</del>
<del>                                     </del>	improper faciline from the manufacturer	
<del>                                     </del>		<del>                                     </del>
<del></del>	<u> </u>	<del>- \</del>
		<u> </u>
<del></del>	Note: This item is the same	1
<del></del>	IG : PCN GEOOLA BY CORT FOR	<del> </del>
<b></b>	the gas tube essign The mon 5: 1 tibe assign in the 4:7/1/2	`\
ļ	53 / 430 assy in the 437/12 100	` ` ` ` ` ` ` ` ` ` ` ` ` ` ` ` ` ` ` `
	12 Kr 85 as compared to the older	
	980214 majol's CA137, This modific	etin
	was to reduce radiction exposure	/
	to the orplanes.	/
/		<del>                                     </del>
7		1
		<del>                                     </del>
	<del>\</del>	
-		
/ /		
		1
11		

DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
05/08/89	Enterview with Donaida Straud	MATPEA
	on PCN 3024/A. As with most	/
	of the ignition excitors, this item	/
$\overline{}$	requires an initial functional rest.	
	IF the steen rosts are it	
<del></del>	is routed back into inventory. The	· · · · · ·
	Fairle rete of this item is reported	1
<del></del>	as ~ 95% so most tems ale	<u> </u>
	overhould. The exciter must be sent	\
<del></del>	to the wiching shop (MATHEM) for	
	1. 1 comoval Note that there is	1
<del></del>	significant dolay timo (24 x12) befor the	ì
<del>/</del>	from is returned to MATHEA. This	ì
	is due to several factors, exercision	1
	The first that the confidence of the confidence	
_/	the birt and state in a mile	<del></del>
<del>-/</del>	for the fack Also note that me	<del></del>
<del>/</del>	for this task Also note that Ms.  Strond reports that 30% of	——————————————————————————————————————
	the disassembled units are found	<del></del>
<del>                                     </del>	+ Jelding for terminal rework or	<del>/</del>
\		<del>/</del>
<u> </u>	cesing repair, Anotter 2" hr	<del>/</del>
<del>\</del>	delay is inculted by this striction,	<del>/</del>
		<del>/</del>
	further surshaul, and sont back to	<del></del>
<del></del>	welding for 1 d'replacement. It can	<del></del>
<del></del>	be soon that there exists the pesc. b. is of a 48-72 hr rielay above and bevon	
<del>\</del>	of a 48 - 12 Al riging about and brushing	<u> </u>
	the specific time required for repair of	<del></del>
<del></del>	mc // ~m.	<del></del>
<del></del>	The con 'col for data'	
	Time required for test:	<del></del>
<del></del>	Time corded fosk:	<del></del>
	A= # =	
<del>/ </del>	PIO \$ 5 Succession for study of lack class operations for all MATRIA support work. Target MATRIM and MATRIM for long delay	
<del>/</del>	back chas operations for all	
<del>/</del>	MIAINCH CUIPORT WORK. 14 SET MATPEM	<del></del>
<del>/</del>	and MATPEW FOR long delay	
<del>-/</del>	limos.	<del></del>
<del></del>	<del></del>	<del></del>
	<del></del>	<del>/</del>
		/

DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
05/09/89	Interview with wender Hawkins	MATPCA
	on PCN 50078A. This .T an	
	ignition exciter which requires an	
	initial function test be performed.	
	It is reported that 90% of	
	the items foil and are overhoulded. The other 10% are routed back into	
	The other 10% are routed back into	
	the inventory.	<u> </u>
		<del> </del>
	an Air Force audit performed which	<u> </u>
	an Air torce audit performed which	<del> </del>
	requires computer tracking and extra	<u> </u>
	saperwork. This is indicated in the	<u> </u>
	operation profile sheet.	
!	·	[
	the components of this item have a high damage potential when exposed to moisture, which requires that the unit is topt in	<u> </u>
	have a high damese solential	<u> </u>
	when exposed to moisture, which	<del> </del>
+	requires that the unit he kept in	
	MAI PEA : dehumiditier (which is	
<u> </u>	packed with dessicent), long drying	<u> </u>
	packed with dessicent), long drying	
	times in both the oven and	
	this dehumidifier are required. The	,
	unit must be sealed and pressurized that moisture does not enter	
	that moisture does not enter	
<u> </u> 7	the cosing. This in turn required cathot high degree of skilled	
	cathot hish degree of skilled	
	coldering be performed around the	
	asing and input leads. Care must	
	to Ken not to heat the casing overly	
77	taken not to heat the casing overly sech during this procedure, as ternal components are heat sensitive.	
	HELMAI COMPUNENTS are heat sensitive	
/ <u>/</u>	IO = 6 Susgest the use of	
	one room of epicky scolant that	
14	ome form of epoxy scolant that yould remove the soldering operation.  This should save much time and	•
<del></del>	CC I be said save much time and	
<del>                                 </del>	Hort by exerctor.	
<del></del>		
<del></del>		

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DATE/PIO#	PIO SUBJECT AND SUPPORTING BATA	RCC
05/9/89	Interview with Mr. wendel Hawkins,	MATACA
	w6-10 on ignition excitor 35510A	
7	This item has an intel for the	(
	test, the results of which determined or returned	
	rather it is overhaused or returned	
	to inventory. It was reported	
	that this item has a solo tailure	
	rate	
	The testing of internal components in this item is a somewhat	
<del></del>	in this item is a somowhat	<del></del>
	complex procedure. Several test stands are required, as well as individual handheld equipment such as chameters and voltameters.	1
	are required, as well as individual	
	handheld equipment such as ohmneter	·
<del></del>	and voltmetris.	
	11/2 1/4 1/4 1/2 1/4 1/2 1/4	
<del></del>	Note that if the internal connectors need to be reworked the item	
<del>/- </del>	must be scat to wolding (MATPIW).	<del></del>
<del></del>	Approximately 15% of all units	
<del>/-</del>	require this additional operation.	<del></del>
<del>/</del> i	All disassembled units will have	<del>/</del>
	the 1:d removed by MATREM and	
/	replaced by MATPIW. Possible	
<del>/</del>	black shap time is therefor	
	48-72 hours.	j
		7
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一个一种人的现在分词

	PIO SUBJECT AND SUPPORTING DATA	RCC
5/10/89	Interview with sames due on	MATPCA
	PEN 38645A TEMP. AMPLIFIER	// / /
<del></del>	PENSON PENON PENON PENS	<del></del>
	This is a very constant	<del> </del>
		<del></del>
	item The teap amplifier is a	<del>\</del>
	matroc item and poly 40%.	<del></del>
	rell the later test and require	<del> </del>
	missibile. Of these, 95% of the	<del> </del>
	Failure involves a modulo failure. There are fixe modulos, and	
		<u> </u>
	each will course a different replacem	Part 1
<del></del>	the A2 models of the A2 models	
<u> </u>	the Ac module If the Ac dishido	
	thills, there is on a 9.0 hour	<u>/</u>
	report time involved that is due	
	11 the ment with the 15 = "\$ 2/2c+	J
	Fit" item which crownes indivious	/
	resting and specifications determinati	
	betale it can be installed (see following	!
/	AID sunsay for).	}
1		\
	There is a great deal of rewiting	\
1	There is a great deal of rewising and resouring of wise, after a modele	<u> </u>
1	chense. RTV sectant must also be	
<del></del>	applied over those wires (which is	<del></del>
<del></del>	very tedious to removo).	<del></del>
<del></del>	1 19 18 18 18 18 18 18 18 18 18 18 18 18 18	<del></del>
1	Functional testing is performed at	
1	three tomporatures franch could tot).	
<u> </u>	with most failure occurre at the	<u>-</u>
<del>\</del>	and to now testor A faction of	<del></del>
<del></del>	cold temporatules. A failure at any temporature will stop testine and require troubleshooting be performed.  After repair or replacement of ports,	<del></del>
<del></del>	reappraise will stop testing and	<u>_</u>
<del>-\</del>	reenire troubleshoring be performed.	<del></del>
	MTHER REPAIR OF replacement of parts,	
	testing must reposted.	
		<del></del>
<del>}</del>	150 5 3	
	PIO # ? Suggest that manufacture supply data of related parts tor "select fit" items. In the case of	er i
	supply data of related parts for	
	splact fit itens. In the case of	
	A2 module, reduce time from 9,0 hrs to	
	~ 3.0 hours for change. (i.e. reduce new)	

ATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
5/10/69	Interview with wellice	MAT REA
	wylie on PEN 38643A, Tomp.	
7	Amplifier.	/
		/
1	This item is rather complex	<del>                                     </del>
<del></del>	in both its testing and repail.	<del>                                     </del>
<del></del>	the amplifier consists of five	i
	maint interest and another	
<del></del>	mejor internal components, any	· · · · · · · · · · · · · · · · · · ·
	item to fail. These internal componen	k.
<del></del> i	and los land a terral Componen	
1	are modulos numbered 1-5. The	,
1	individual failure rates are listed on	<u> </u>
1	the operation profile short for oper.	<del> </del>
	157-153	`
<del></del>		\
	This item is classified as a	<u> </u>
/	MATROC item, and requires an initial functional tost be performed.	
/	initial tunctional tost be performed.	
/	80% at all amplifiers of this typo	1
/	tested pass the test. They are the	<u> </u>
/	returned to investorie. The other	!
/	twenty percent regaine disassembly and	7
/	relacement of more or more modules.	/
1	It should be noted that the complified	
1	interior is sealed with a pottine compose	nd /
	interior is scaled with a potting compoundich is very difficult to remove. Note	
Į.	that the amplifier fails mostly during	<del>/</del>
	the embient temperature phase of testing.	<del></del> -
	The state of the s	<del></del>
1		
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\		
\		<del></del>
<del>,</del>		
<del></del>		
<del></del>	<del></del>	
<del>:</del>	· · · · · · · · · · · · · · · · · · ·	
	<del>-</del>	<u> </u>
		<u> </u>
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DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
5/16/89	Interview with mr. Hunshrew on	MATRA
	PEN 6/234A, ignition exciter.	
	1	
<del>-/</del>	The 1/2 1 224 121	
<del></del>	This item is not designated	
	a MATROC item, but most technicia	· S
<del></del>	functional test as fort of their	
	functional traff as fort at their	
· · · · · · · · · · · · · · · · · · ·	trouble-hosting Hocadure. This item	
<del></del>	is coperted as having a 40% yess rate	
	of these invested tests. This would	``
	seen to indicate that making this a	
	"salective's recharded" How is a viable	
	cot.'sn.	
	Note that there are several internal	
<del></del>	components in this peritor which can	
<del></del>	Line I I done with	
<del></del>	fill and cuch of these will take	<del></del> -
	a different repair time. Also note that	<u> </u>
<del></del>	there is after the possibility of more	
	then one internal component tailing	
\	at any one time	
	It should be mentioned that this	
7	exciter's tube assemblys are installed	
	in a formed rubber casing. This cosing	
	is position as = out of the other office.	<del></del>
	while installed	
	White 1/23 14//22	<del></del>
<del>/</del>	A- # C S / // //	
<del>\</del>	PIO # 8 Suggest that this exciter	<del></del>
	to take advantage of 40% 1055 1040.  Mention transformer inspections	<del></del>
	to take advantage of 40% loss 104.	
	mention transformer inspections	
	PIO = 9 suspest that focus	<u> </u>
	study be performed an all excitent	
11	PIO = 9 Suggest that focus study be postormed on 11 exciters as well as many other electrical accessory items can using the or potting compound, Explore fasibility of using formed rubber having (prevents arcing, protects from shock, sools, etc.).	. /
7-1	CERCEALU IA CO CONTRA C	
<del>/</del>	or de the	<del></del>
<del>/</del> +	- porting compound, explore teast. I. A.	<del></del>
<del></del>	of using formed l'ubber housing (prevents)	
	arcine, protects from shock, seels, etc.).	
1		

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DATE/P10 #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/16/89	Interview with Mr. Hundhow on	MATACA
	PCN 50217A, ignition excipi	
	1	
	This item is besidely istrational to	
	the ignition exciter PCN 51234A.	
	Again no initial function met is	
	This item is besically intiral to the ignition exciter PEN 51234A.  Again no initial function rest is required, aithough isculleshooting before	
<del></del>	Overhand indicates that 40% pot all	<u> </u>
<del></del>	items tosted are fully franctional.	
<del></del>		
<del></del>	The only real differences winting	<del></del>
<del></del>	botunes the two aforementioned ACNS	
<del></del>	is the 50217A as two capacitors in the capacitors to one in the 1.1234A. It should also be noted that instead of ATV	<u> </u>
<del></del>	to the cape, has a copposed	<del></del>
	c/so be noted that is stall of ATIL	
<del></del>	being used as an internal insulator	<del></del>
	and could a bendaring insulator	<del></del> -
	and sealer, a hardening compound is sourced into the exciter during	<del>/</del>
1	closcrut. This Forms a hard plastic	
	cover which is time-consuming	
	to remove	<del>/</del>
	,	j
	PIO = 10 Sugarst usa of ATV  scaler as in case of 1-1234A.	
	scaler as in case of 1-1234A.	\
	Much casier to remove.	
	PIO = 11 Same as suspestion	<u> </u>
	z 6.	
<del></del>		
<del></del>		/
<del></del>		/
<del>  </del>		
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<del></del>		
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<del></del>		<del></del>
		<del></del>
<del>/</del>		

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	DAILY ACTIVITY LOG	
DATE/RCC	SUBJECT/ACTIVITY	NEXT ACTION/ ASSIGNMENT
05/15/89	Interview on solenoid ASSY (38694A).	MATRCA
	This item will have the the casing	
	noticed and a visual inspection performed	
	IF all internal components are within	
	opened and a visual inspection performed.  If all internal components are within wear limits, a functional test is	
	performed. 20% of all items are	
	judged fit to be returned to inventily.	<del></del>
	Tulacround time is two hours in these	\\
	cases. 80% of these items require	<del> </del>
<b>——</b>	overhaul. If the armiture assembly	<del> </del>
<del></del>	must be removed, the item is sent	<del>                                     </del>
<b> +</b>	to welding, Turnaround at MATPIW	<del>                                     </del>
<i> </i> -	is estimated by the interviower as 72.0 hours average. This is due	
<del> /- </del>	4 the to he had les reached as a	
<del>/-</del>	to this item being designated as a low priority tem.	
<del>                                     </del>	1800 pirating them.	
<del></del>	To rebuilding this item an	
-/	internal actuation device must be adjusted	
/	internal actuation device must be adjusted by plecement of shins and wasters.	
	the possibility exists for multiple teardown on each item. This was reported as rare.	
	the possibility exists for multiple teardown	
	on each item. This was rejorted as rare.	
! \	·	
	total time required for rebuild	
	is 3.5 hours.	<b></b>
<del></del>		
<del>- \                                   </del>		
<del>                                     </del>	PEO # 12 Absorvation of improperty	
<del></del>	desend had sools ( nower and annual)	<del>                                     </del>
<del></del>	esigned hard tools (power and manual)! suspest use of Eggonomical tool designs.	
<del> </del>	destrat	
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-/-1		
<del>-/</del>		<b></b>
<del>-/</del>		<b> /</b>
<u>`</u> i		

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DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
05/19/89	Interview with wender Hawkins	MAT REA
	on PCN# 97133A, Electionag 3-way select value,	
	This item is rebuilt each time	
	it enters the depot, and a rebuild	
	one port of the value is closed off by the user organization	
	due to this items modified use as	
	specifications still in effect require	
	that the value be tested on the fuel transfer equipment located in	
	bld. 3108, This test utilizes the third port normally plugged while in use on give aft engines, and	
	would appear unnecessary.	
	It should also be noted that	
	there is no specific requirement to leak test the value with compressed	od .
	the test equipment in 3108. If the	
	effied they the test using the	
	fuel transfer station could not be performed.	
	In # 13 Suggest the tot	
	requirement for fuel transfer procedure be deleted from tech data.	
	of the value with compressed	
	TO # 14 Suggest that testing of the value with compressed wir before being sent to fuel transfer testion in bld. 3108 (if above DIO	
	not exceptable).	

Car

DATE/PIO # PIO SUBJECT AND SUPPORTING DATA  S/19/89 Enterview with wends I Howth MATPICA  in PCN # 34551A, Solenoid Valve.  This ifem is 100% overhand.  Operations 1/5 to 170 of the who (CAREON) are performed in building 370% by personnel assimod to did feel testing facility.  A rebuild kit is required  For each solenoid velve that is Overhanded.  Total time for retuild, including time in bld. 3108, 14.16 hours			
This item is 100% overhaul.  Operations 115 to 170 of the  wco (CAEZO4) are performed in  building 3108 by personnel assissed  to the fuel testing facility.  A rebuild Kit is required  For each solenoid value that is  overhauled.	DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
This item is 100% overhaul.  Operations 115 to 170 of the  wco (CAEZO4) are performed in  building 3108 by personnel assissed  to the fuel testing facility.  A rebuild Kit is required  For each solenoid value that is  overhauled.	5/16/09	Tateria de il lale del Haute	MATACA
This item is 100% overhaul.  Operations 115 to 170 of the  wco (CAEZO4) are performed in  building 3108 by personnel assissed  to the fuel testing facility.  A rebuild Kit is required  For each solenoid value that is  overhauled.	2///01	Part # 2015-C-11 Color 1 1 1 1 1 1	/
Operations 115 to 170 of the wco (CAEZO4) are performed in building 3108 by personnel assissed to the fuel testing facility.  A rebuild Kit is required  For each solenoid value that is overhanded.	<del></del>	EN PEN 3433 IA, SOIENDIO VAIVE.	
Operations 115 to 170 of the wco (CAEZO4) are performed in building 3108 by personnel assissed to the fuel testing facility.  A rebuild Kit is required  For each solenoid value that is overhanded.			
For each solenoid value that is overhauled.		This item is 100% overhaul.	
For each solenoid value that is overhauled.	\	Operations 115 to 170 of the	
For each solenoid value that is overhauled.		WCD (CAEZO4) are performed in	
For each solenoid value that is overhauled.		building 3108 by personnel assigned	
For each solenoid value that is overhauled.	<del></del>	to the first testing failit.	
For each solensid valve that is overhauled.	1		
For each solensid valve that is overhauled.	<del> </del>	A pahild Kit is now isal	<del></del>
overhauled.	<del></del>	7 / EUG. 10 / 13 / Equ. 160	
	<b> </b>		
Total time for retuild, including  a 12.0 hour mendatory flow  time in bld. 3108, 14.4 hours		over hauled.	<del></del>
time in bld. 3105, 14.6 hours			
time in bld. 3108, 14. bl hours.		Total time for retuild, including	
time in 6/d. 310\$, 19.16 hauts.	7	a 12.0 hour mandator. Flow	/
	/	time in 1.1d. 3/08 14 4 Lours	7
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DATE/PIO#	PIO SUBJECT AND SUPPORTING GATA	RCC
<i>ې خور ۱۹</i>	Interview with Aichard Franklin	MATRCA
	about Automotic Iguition Actuated,	
	PCN 351114	
_/		<del>  / </del>
<del></del>		
<del></del>	This is a 100% overhaul	
<del>\</del>	item. It requires a discognish	<del>\</del>
<del>- \</del>	and visual inspection as well as	<del></del>
<del>\</del>	electrical testing.	
<del></del>		
\	Note that there is a requirement	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
\	to electrically test the activition	\
	switch in the cover & switch	<u> </u>
N. Committee of the com	assembly, Under present conditions	i
	if the switch tosts bad the	1
ĺ	la tima conscribing	
	The switch is set into the housing	<del></del>
	14/ 14/ 14/1	<del></del>
<del>/</del>	with a special potting confound.	<del></del>
<del>/</del>	aciloty	
<del>/</del>	BFNDIX Corporation, Bendix also	<del></del>
<del></del>	manutactures the cover housing.	
/	Technicians report that they are	
/	unable to obtain the potting confound	<u> </u>
	and must replace the entire	\
	housing assembly is a unit. The	
	east of a now housing assembly is	_\_
1	180000 which walker the policiance of	
\	Bendix in providing the latting compound	
	as techty susport.	<del></del>
\		<del>/</del>
<del></del>	PIO # 18 Suggest that Bendix be	<del>/</del>
<del></del>	December 42 call hold will	<del>/</del>
<del></del>	PIO # 18 Sussest that Bendix De Pacouraged to sell both the potting compound and small switch assume to user argonization. This cover housing assume should be a repairable tem.	
<del></del>	porting compound and smell switch	<del>/</del>
<del></del>	assu, to user organization. This	
	cover housing assir should be a	
	repairable tem	
		\
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<del>-/</del>		<del></del>
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DATE/PIO#	PIO SUBJECT AND SUPPORTING DATA	RCC
5/19/89	Interview with LARRY Ware	MATRA
	The Contract of the Contract o	7777
	on ignition exciter PCN 5-0297A.	<del></del>
<del></del>		/
	This is a MATROL item	
1 \	which requires an initial function	/
	test Fine secret of all the s	
<del>\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ </del>	which requires an initial function test. Five percent of all items tested fail and must be overhouse.	
<del>                                     </del>	The rack of Carl and I wanted	<del></del>
<del></del>	The rost are returned to inventory.	<del>\</del>
<del></del>		<del> </del>
<del></del>	Note that there is are 24.0	<u> </u>
	hour delays at both the machini.	19
	(mathem) O and welding (MATPIW) -	
	backshop operations.	
<del></del>		<del></del>
<del></del>	This item must be sandblosted and painted after overhauled. A	
<b>————</b>	and painted after overhauled. A	
	rebuild xit is required for each	
	overhould item	
<del> /</del>	1 - 4 1 - 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1	<del></del>
<del></del>	DIO # 15 Humidity control chamber	
<i> </i>	required in MATPCH area. Presontly	
<b></b>	using an oli retrigerator packed	
	with decision t	
		7
		<del>/</del>
		<del>/</del> -
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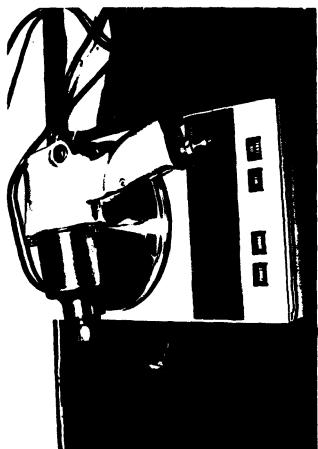
TE/P10 #	PIO SUBJECT AND SUPPORTING DATA	RCC
175 189	Enterview with Natural Franklin	MAT PCA
	on PrN 35113 A. Control relay	سر
	60×.	
<del>/</del>		
<u></u>	This item is a MATPOC desirently	
	but pass rate is only about 5%.	_
	Note that a major internal component	
\	is the amplifier assembly. This	
<u>,                                      </u>	component is produced in ENGLAND	
<del>`</del>	at a constant of 12 700 00	
<del></del>	at a purchase prior of \$2,700 00	<u> </u>
	The conjunent is often repeireble	<del> </del>
	at a cost of 100 or less. No	
	repair time is allowed for these	
<u> </u>	components.	
1		
<u> </u>	PIO # 16 The amplifier assy, for	
	the Control May box PM 35113A	
	should be made a Mpaicable item	
	and have a standard Collair time	
	assigned to it. Average sovings	
j	per component: 2600 ==	
	ALO = 1) Focus stucy should be	
	performed to specifically identify all repaired	le
	norts, and a dutailed cost analysis	
	medo to compare costs of	
1	repair us. replacement of individual	
	components.	
	, ortification	<del></del>
		!
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DATE/PIO # PIO SUBJECT AND SUPPORTING DATA RCC Interview with Donelda Stroud 5/22/85 MATPCA on PCN 35033A sensor. returned to inventor a visuel exists. en plectrical 10st reassembled and roturn to inventory of all sensors fail either the visual or electrical inspections. all those require replacement of the Germinal hound itself. There are then retested and reassembled if now functional.

size to terview with tranklin martin matter  on New 34252A, Flowmater Park.  Supply.  This WR Supply is a MATROC  Idesignated item! Transicians report  that only 520 of the tested  items are functional, the rest resulting  overhand.  Note that the internal circuit  topard of this item is reposable.  The technicians will do this report  in their space time, who makes  Itespensitisty in this Again this  are not given a standard time  to work those and any reposit  is therefore into the initiative  if the Employee. Cost of  replacement: 20 Cost of reposit;  was much this time  Note: This item is the same  Note: This item is the same  Note: This item is the same  are introhanceable.  ITO = 19 Succest a focus study  be petformed of cost-benefit  be repositive the internal circuit  boards mentional alrow, should include  cost engless of repair us replace,  economic order quantity of parts, etc.	: <b>C</b>
con PCN 34252A, Flourmeter PWR.  Supply.  This WR Supply is a MATROC  Moscanated item. Trahascians report  that only 50 of the tested  items are functional, the rest required  overhaul.  Note that the intercal circuit  knowed of this item is repairable.  The technicians will do this crain  in their steer time, the intercal  in their steer time, the intercal  for not size of assigned a primary  responsibility of this Again this  are not size a standard time  to work these and any repair  is therefore with to the initiative  of the employee. Cost of  replacement: 2nd Cost of repair  white at this time  Note: This item is the same  Les PCN 34253A in all respects except  The housings. All infernal comprehenses  are interchanceable.	TPCA
Supply.  This OWR Supply is a MATROC  rosianated item. Technicians report  that only 50 of the tested  items are functional, the rest requiring  overhaud.  Note that the internal circuit  board of this item is repairable.  The technicians will do this repairable.  In their spare time, the marked a primary  lesponsability in this, Again they  are not siven a standard time  to work these and any repair  is therefore into la the invitative  of the supplayer. Cost of repair  undrawn at this time  Note: This item is the same  as PCN 34253A in all respects except  the housings. All internal compression  are interchanceable.	_
This WR Supply is a MATROC  rosionated item Technicions report  that only 5% of the tested  items are functional, the rest requiring  overhaul.  Note that the internal circuit  board of this item is repairable.  The technicions will do this repoir  in their spare time, the minimum  responsibility in this Again this  are not siven a stendard time  to work those and say repair  is therrore into a the invitative  to the supplying Cost of repair  ceptacement: 30 Cost of repair  working at this time  Note: This item is the same  Les PCN 34253A in all respects except  the housings. All internal comprisents  are interchanceable.	<u></u>
Note that the internal circuit  thoused of this item is repairable.  The technicians will do this capair  in their spere time, the image  to the siven a standard time  to work those and any repair  is therefore into the initiative  of the supplement cost of  replacement: 2nd cost of repair;  undrawn at this time  Note: This item is the same  as PCN 34253A in all respects except  the housings. All internal compensats  are interchanceable.	
Note that the internal circuit  that of this item is repairable.  The technicians will do this copies  in their spare time, the internal  tot are not assigned a primary  lesponsibility in this Again this  are not given a standard time  to work those and any repair  is therefore into the initiative  of the Employee. Cost of  replacement: 3nd Cost of repair;  undrawn at this time  Note: This item is the same  as PCN 39253A in all respects except  the housings. All internal compensats  are interchanceable.	
Note that the internal circuit  topard of this item is repairable.  The technicians will do this cape.  In their spare time, the internal  tot are not assigned a primar,  lesponsibility in this Again this  are not given a standard time  to work those and any repair  is therefore inft to the initiative  of the Employee. Cost of  replacement: 3nd Cost of repair;  untrawn at this time  Note: This item is the same  as PCN 39253A in all respects except  the housings. All internal compensats  are interchanceable.	
Note that the internal circuit  toard of this item is repairable.  The technicians will do this cape.  In their spare time, the internal  tot are not assigned a primar,  lespensifility in this Again this  are not given a standard time  to work these and any repair  is therefore inft to the initiative  of the Employee. Cost of  replacement: and cost of repair;  untrawn at this time  Note: This item is the same  as PCN 34253A in all respects except  the housings. All internal compensats  are interchanceable.	
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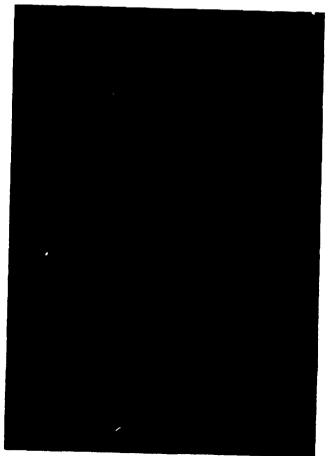












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	3.QUANTITY  4.PROD GLUTTON/RCC (5.DA) 2   mypcaj   890	
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000   	MITTAL GELD FILTER AND GUIPUT TERMINALS. NEG. NOT REQ.	
510	REPAIR OR REPLAUL AS NUCLUSARY.	
4929 320	REASSEMBLE.  O: 40.0 / Con 174	
V 00 000	MIPIW # 3903 MOVE TO WELDTED SHEET MITTER FROM DIX- AND WELD COVER WITH FIRETR ROD DIX- WELD NO. 35 AND ACCOMPLISH LEAK TEST	
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	020	DISASSLMBLE.	1	120		
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n — пъщон. (	120	TEST VIBRATOR IAW T.O.	i	6	100	JP 04
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DEI	440	I TORQUE ALL INSIDE SCREWS & NUTS AND	1 L 71			i 
		I INTERMEDIATE TEST: APPLY 14 0 FOR 10 I SECUNDS MAX. OBTAIN 3100 34000.  I ACT:  I THOUT VOLTAGE  I THOUT VOLTAGE  I APPLIED (MINIMUM)  AUTUAL  AUTUAL  I CONTINUOUS DUTY CIRCUIT (EST: OTOR)  I ACTUAL  I CONTINUOUS DUTY CIRCUIT (EST: OTOR)  I ACTUAL  I CONTINUOUS DUTY CIRCUIT (EST: OTOR)  I ACTUAL  I CONTINUOUS DUTY CIRCUIT (EST: OTOR)  I ACTUAL  I ACTUAL  AMP  I SPARK RATE, LEFT HAND OUTPUT, 10-20  I CPARKS IN 10 SECUNDS.  I TRIGGERING CIRCUITS TEST: APPLY 24  I VDC FOR 10 SECUNDS. CONSISTENT  I SPARKING MUST BE OBSERVED IN WINDOWS  I OF BOTH TESTER.  I TASER SHORTING CAP TO GRE TESTER AT  I A TIME. MUST WORK CORRECTLY.  I TESTER #1: GAP 0.200, 25 FOIG.  I CESTER #2: GAP 0.100, 5 FSIG.  OBTAIN GAP 0.200 IRCH, 20 FSIG. "C"  I PIN 115 V 400 CYCLE. CONSISTENT  I SPARKING.		9	Tas	111-49
· • ·		I FILL WITH POTTING COMPOUND I AND BAKE IAW T.O. FLOW 180 MIN	i 6	1 1	i 	;
	525	TORQUE ALL SCREWS OR NUTS OUTSIDE OF I CASE. IAW T.O. (SOLDIER SEAL CASE)		1	i i	! !
	530   	TEST FOR LEAKS: APPLY 15 PSIG. LEAK-   AGE 1 X 10 -6 CUBIC CENTIMETERS PER   SECOND MAXIMUM. (ALT LEAK CHECK IN   WATER)   ACTUAL	i n		395	2
	540	30 1 20 040	m 6		i	- 7
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!	<b>}</b> 	REASSEMBLE TAM ( 0). S. NOTE: BAKE PROBES PRIOR TO RED CHECK TAM NOTE PARA, 4:5				: :
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· · · · · · · · · · · · · · · · · · ·	<b>!</b>	I I HEATER PROBE (EBŤ (EBP S I (JETCAL AMALYZER) I ACT I ENTER ACTUAL TEMPERATURE	SPREAD.	1 m	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	! !

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		RECEIVE, IDENTIFY AND   PAPERUORK.		l I ri	1	
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	<b>****</b>	APPLY DO VOC FOR 5 SE BETWEE FACE PIN AND B		1		
		ACT:	ML BOILMS.	1 1	<b>!</b> !	   
·	060	AND (S-4).	(1-2)	1 11	"	· · ·   
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	-16.FUN/ IOP NU.	117.WORK TO BE ACCOMPLISHED	113.MECH	<b>17</b> "P"   20"a'
	090	REPAIR OR REPLACE AS NECESSARY.	n	
	100	REASSEMBLE.	1 1 1 7	] · · · · · · · · · · · · · · · · · · ·
• • • · · · · · · · · · · · · · · · · ·	110	FORMUE SOREWS (12).    ACT: LU IN   ACT: LU IN   ACT: LU IN	m	
3105	1	FIREDRA LOW PRESSURE FLOW LEAKAGE FACTOR OF A 330 POIG. NO LEAKAGE FALLOWED OVER A FERIOD OF 2 MINUTES.	7	
Konting Symbo	130	PERFORM VALVE LEAKAGE (EST A)  1 1900 F910 LUN & MINUTES. NO  1 LEAKAGE ALLOWED.  1 85 TEST STAND#8	/i i m i	
	140	CALIBRATION: CHECK FLOW THROUGH   VALVE.	1 7	
· · · · · · · · · · · · · · · · · · ·	150	ACT: LB/HR CHECK LEAKAGE FROM OUTLET CONNECTION. L. ACT: CC/MIN	r.	in 310
! !		I APPLY 1930 PUID INLEY PRESCURE. I NO LEAKAGE EXCEPT PROD OUTLET I CONNECTION.	m	
• • • • •   		I APPLY 130 PSIG. NO LLAKAGE I ALLOWED OVER 2 MINUTE PERIOD.	1 1 1 1 1 1 1	
W-43		PAINT NUT NEE OE		··· ·   ··· ·   ··· · · ·   ··· · · · · · · · · · · · · · · · · · ·
	178	BECOMICAL CHECK AFTLY SOC USE SECUNDS BETWEEN EACH FIN AND RESOURCE.		! ! ! ! ! ! ! ! ! ! ! ! ! ! ! ! ! ! !
		FORWANDED TO DATA AUTUMATION.	1	
	•	I CERTIFY THAT THIS END LIEM HAS BEEN OVERHAULED LAW T.C., TUTG, CUMRENT REVISIONS, SUPPLEMENTS & AFFLICABLE PROCESS ORDERS.	M   Sn.'n	1 1
		OFERATIONS COMPLETE AND PAPER-	n	; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ; ;
		COMPLY WITH MAUT 65-35, PARA 13	1	1 1

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2.URIG/F 35023	PROD NR 3A	3.QUANTITY   4			15.DATE 1 890		16.DATE	CUMP
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		117.WORK TO BE		ALD		118.71 CI	1119"1"	leo"W"
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· · · · · · · · · · · · · · · · · · ·		i FRELIMINARY FANCE BETWEER FORGUND FAVIVMA AR	CHECK: MER LOUTPUR TEL	RMINAL A	dbi		· · · · · · · · · · · · · · · · · · ·	
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		FAPPLY 21.0 V F SPARKS PER S F			" ()	}  - 19  -	1	; ; ;
		I TEST TRIGGER I CAP & INTERN			FOR	1 7		
		   ACT   APPLY 21.0 (   OBTAIN CONSI	OLTS/RMS 40	O CYCLL		1 1 1	! ! !	; ; 1
		PRESSURE TES   180 DEG F M] 						;
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ISTATION	OP NO.	17.WORK TO BE ACCOMPLISHED	118.MECH	19"6":	
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	090	CLEAN AG REQUIRED.	i		
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i i i i i i i i i i i i i i i i i i i		FLASH HLST CAPACITOR: IAW T.O.	}	• • • • • • • • • • • • • • • • • • •	
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	i l i	I "D" TO CASE - I AUT:UF	 	 	<b>!</b> !
	 	"B" TO CASE -   ACT:OF   *CAPACITER BRIDGE TESTER*		} !	1 1 1
	1 150 	FILTER TEST: IAW T.O.	l m	1	1
	<b>}</b>	ACT: OHM  I APPLY SOO VOLTS DC BETWEEN PINS OF  I INPUT RECEPTABLE FOR ONE MINUTE MIN  (CONTINUED)	   M	l 	 

TATION	UP NO.	117.WORK TO	BE ACCOMPLISHED	ı	118.MECH	119"P"	12000
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	l İ	!   #2	ACT:VOLTS	1		i 1
	<b>!</b>	l l #3	ACT:VOLTO	1	 	
		   #4	ACT:VOLTS	i i	 	i
		l Discha l l	GROUR TUBL TEST: IAW T.U.	i m		; 
			ACT: CUNSOLE, VOLTASCOPE, ARGER TUBE TESTER»		1	:
	2.50	i iiIGH i	Englow Choucafor restriau t.o.	, n	· · · · · · · · · · · · · · · · · · ·	i ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' '
	I	i	TRANSFORMER TEST: 1AW 1.0.		" ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' '	1
	1 1	i MEASUR I MAGNO I	RE KL31STANCE SETWEEN TWO SEC- ( LEADS.	i i m	i i	
14M-17 - MH 12-1	 	I AUT	GIMS ACTGIMS		<b> </b> 	1
			1.5 VOLTS BETWEEN PRIMARY IN- EAD & GROUND. EXCITER CURRENT	1 1:	[ ;	!
		 	AUT:AMP			
			VOLTACCOME WAVEFORM FOR "HASH" DO VOLTS MEAK OR SECONDARY.			1
			ENSION TRANSFORMER TEST: CONTINUITY.	1   1	 	 
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1 100	TO CORRECTY THAT THIS END LICH HAS I FELD GUICHAULLD JAW T.U., TUTU FOURBENT REVISIONS, SUPPLEMENTS & FATTICABLE TROCESS URBERS.	H H		; ; ; †
!	OFERATIONS COMPLETED & PAPERMORK   PROCESSED	1 1 1 7	1	} ·· }
1 155	I COMPLY WITH MADE 66 35, PARA 13		- 1	1
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		13.GUANTITY 14.PROD SECTION/RCC 15.DATE 1 H MIPCAP 1 890	
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នេះការនេះ ទោកការ		FIX MORE TO BE ACCOMPLISHED	118.MCCH119"1" (26) 8"
1		; ;	
13 4.5 <u>1</u>	010	FRECEIVE) COENTIFY & ATTACH PARCHWORK.	i interior
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4 2 2	680	: Disassemble.	I ROUTIN
1	630 630	CLEAN AS REQUIRED.	1 3CmZm1' 1 1
1 1	040	FINSPECT AS REQUIRED.	1 . 5
! 1 ! !		I CHECK THE ELECTRICAL OPERATION OF I SWITCH CONTAINED IN COVER & SWITCH LASSY.  MOHAMETER - Hand - Tool's	,5 m = 1
\$ \$ \$ 1		CHECK LEAKAGE REGISTANCE OF EACH CONTACT PIN 3 THE SWITCH HOUSING. I MINIMUM ALLOWABLE RESISTANCE SHALL BE WITHIN SPECIFIED MCCOHMS.	MENCEN
		LACT: ACT: L×500 VOLT MUGGER	
	626	REPAIR AS NECESSARY.	1.15m=1
		FRACE COVER & SWITCH ASSY IN OVEN & FIRM 1 HR. AT 350 DEG. F. 10 LOGSEN	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1

: !	CAEZOS	÷#XXXXXXXX F# <b>₩ORK</b> C - 16.1°ON/	SAXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX	PAGE 2	0F 4	PAUES)
i				ta Mech	124641	30.48 . [
: ا حمد		-Lute	POTTING COMPOUND.			
		1 090 1	WIPE SWITCH WITH A CLEAN CLOTH	f=1		
† †		1;	act thes		i 	
; ; ;	;	\\ 1\\ 1\\ 1\\ 1\\ 1\\ 1\\ 1\\ 1\\ 1\\	POSTTON THEMS PREVIOUSLY REMOVED THEFT THE COVER WITH HOLES LINED UP & CHOTALL BRACKET & SMITH ASSY USING 2 LARSE ALIEN HEAD SCHEWS & LICKMASHERS PREVIOUSLY REMOVED. TORRAGE SCREWS FIRMALLY LARGE.	f <sup>c</sup> f		
; ! !			ACT THATES	 	 	
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	/		AT THE HOMENT CMITCH FLUMBER TRIPS SWITCH TO ON, DISTANCE FROM FLUMBER ACTIVATING LEVER TRIP TO COVER PART - I THE COURTAGE SHALL BE MITHIN PRESCRIPTO LIMITS. ACT: IPCH			
بسم	<b>y</b> 2	1 1	ADEPTH MURONETER	 	  -	
<b>-</b>	, ·		REPLACE AS NECESSARY.	l I jej	<b>!</b>	;
. !	•	, ,	EUDRICATE AS REQUIRED.	1.50=	-	
; ; ;	 ¥	1	REAGGEMBLE	.30mzm	· · ·	i I
1		11:0	TORREL ADAPTER REQUIRED			1
;			*TORANG PRENCH	l fi		
1	,		INSTALL SCREWS THEN SUCCESSIVELY & GRADUALLY ITCHTEN DEAGGNALLY OPEN SITE SCREWS UNTIL DIAPHRAGE IS DEAFN DOWN EVENLY. FORGUE SCREWS WITHIN INVERS LIMITS.	it it		
1		!	ACT:		 	
	) }		) THETALL SEREWS, SUCCESSIVELY & GRAD- UALLY TIGHTEN SCREWS UNTIL COVER LS DRAWA DOWN CVENLY, 10PQUE SCREWS 10 REQUIRED INVLSS.	M		
7	•	i !	AC f *		; 	: ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' '
1 1 1			POSTITON SUREM IN CONTER HOLE OF SMATCH HOUSING, THREAD SCREW INTO (CONTINUED)	, 5mIW	[ ]	

	-sessesse -s NORR ( -16,Ph)/	CONTROL DOCUMENT # JC 1.DATE 89222	PAGE 3 OF 4 PAL	78.A #1011
ISTATION			1 <b>18</b> .6661111225 (126)	, Q - [
		HOUSING UNITE MAX DEPTH IS REACHED		1
		ACT: CNUL	1 1 1	!
1	120	SPRING ADJUSTMENT DURING ASSENBLY. DOTAIN ACT PRESS BASE OF 4.4 PSI.	1.15111	1
} 	1 200   	INSTALL THE ADAPTER IN HOLL OF COMER & SWITCH ASSY. TURQUE ADAPTER TO PRISCRIBED LIMITS. ACT: (N/LRG)	1 N 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	! ! !
1 1 1 1	2to   	THEEK & INSURE WASHER IS STELL ALLOWED. INSTALL SERING & 1998 IN HOUSING. TORQUE PLUG WITHIN LIMITS	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	; ;
1		ACT 4 UNZUBB		1
	220   	(NOTAL) VALVE AGBY ON GMETCH HOUSEND TORROW, VALUE BODY TO PRESCRIBED J. CMETS. ACT: INZIES	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	; ; ;
} - · · · · · · · · · · · · · · · · · ·		TEST SWITCH ASSY FOR LEAKAGE.	1 · · · · · · · · · · · · · · · · · · ·	
5		THEAR DETECTOR TESTER SELECTION		1
1	$\frac{240}{1}$	CESTING,	1.50 IN	1
† · †	COVER	- HAK: - CONNECT AIR HOSE ASSEMBLY	1 1 1	i i
	, , , , , , , , , , , , , , , , , , ,			i
1 .4 1		ADJUST THE AUTUATOR FRESS REGULATOR UNITE ACTUATOR PRESSURE GAUGE INDICATES 7 PST RED NOT REU		; ! !
		DEPRESS AND HOLD TEST BUTTON ON TEST SET TO DECREASE ATT PRESSURE ON SWITCH ASSEMBLY. THE ACTUATOR SWITCH HALL NOT COME ON.	1 19 1 1	1
; ; ;	280 °/¶	PARA 7:3. SUB PARA 6		; ;
, } !			1 1	1
•	•	OBSERVE HOW LONG AUTUATOR SWITCH DADJECTOR OF TEST REMAINS LIT. THIS IS THE "ON" TIME OF SWITCH ASSY. "ON" TIME SHALL BE WITHIN LIMITS. ACT.		1
1		ADJUST THE ACTUATOR PRESS REGULATOR UNTIL ACTUATOR PRESSURE GAUGE IN- (CONTINUED)	1 1 1 1 M 1	1

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)	1	I DICATES 7 PSI. I SECOND TO INLET ADAPTER OF SMITCH I ASSEMBLY. I REQ: NOT REQ: I XLEAK DETECTOR TERRIERS	2 mIm	
		FOR READJUSTMENT OF SCREW (20) MAS FREQUERED, REPEAT THE 13 PS) CHECK. FOR ACT:	Marzon	; ;
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		I SPARK CAP. CAPACITANCE HELDER ACTION IN 3500 VDC FOR 15 GEOONDS MINIMUN I MINIMUN.	
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	!	FIGURE A COMENTIAL OF 4000 V DO BE FIGURE LOADS FOR A PORTED OF AST 1000 FINAN 10 GEC OR NOT MORE THAN 20 GEO.	
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; ;	250	T REAGGEMBLE.	1		i i i i i i i i i i i i i i i i i i i

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	nipiW	MOVE TO WELDING SHOP TO CELD 1.30. TEST AS REQUIRED.	i i		: : :
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	-   310  -  -  -	TEMPERATURE VS ENGINE SPEED TEST  ALTERNATUR FREQUENCY F		· · · · · · · · · · · · · · · · · · ·	
·		0-70 62.9 010 708 630 660			
· · ·		FRERUENCY RESPONSE TEST  27 LINES, FREQUENCY .30 TO .35 000  ACT:  35 LINES, FREQUENCY .45 TO .04 005  ACT:			    - 
	1 230 1 30 1	SPEED DERIVATIVE TEST   .1 CPS (23-29MV)	1 11 11 11 11 11 11 11 11 11 11 11 11 1	1	
40/10 /	340	GHOCK TEST 10m.7 OUTPUT DIFFERENTIAL CURRENT.	i - 11 - 11 - 11 - 11 - 11 - 11 - 11 -		
	; <b>•</b>	MECHANICAL PRESSURE TEST /0 //	1	   	
	   360 	VIBRATION TEST 30 ~ ~		   	
	-44	HIGH TEMPERATURE TEST	i 1 m	 	! !
		COMPLETE & FORWARD AFTO 349 10 DATA     PROCESSING.			
	390 	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TOTO CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.	5-		
ran in the special		OPERATIONS COMPLETE, PAPERWORK	# 2 -		· · · · · · · · · · · · · · · · · · ·

CACIONIOP NO.	**************************************	118.MECH  19"P"   120"(
410	COMPLY WITH MAUI 66-36, PARA 13   TYPE WORK PERFURMED	Im/ a.h
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		CONTROL DOCUMENT * 72-10		PAGE 1	OF 5	PAGES	L
2.ORIG/		13.QUANTITY 14.PROD SECT			6.DATE	COMP	1
7.PART 44387	NUMBER	•	18/12.TECH DATA   PO-MAT86-3   8E1-8-9-3	/OPTIONA	-		! ! !
TF33-	PW102	/SERIES!11.STOCK NR   2925011615596RV	CHG 9		•	14153H	1
13.MISC		/END ITEM NOUN ON EXCITER	! ! !				1   
	-16.PDN/						1"
STATION		117.WORK TO BE ACCOMPLIS		118.MECH	19"P"	120"0"	i I
W-43	010	RECEIVE, IDENTIFY & AT	TACH PAPERWORK	i I m	!		!
	‡ [	ALL REFERENCES ARE TO 8 APPLICABLE PROCESS OF DATA CONTAINS DETAILED CAUTIONS, WARNINGS, DIF TOLERANCES REQUIRING CO	RDERS. TECH NOTES, MENGIONS &		i 	1 1 1	! ! !
	1 020	I DISASSEMBLE.		1		1	1 1 '4' 1
	1 030	CLEAN AS REQUIRED.			   	ł l	! !
	1 040	I INSPECT AS REQUIRED.	* * * * * * * * * * * * * * * * * * * *	1	}	!	1
	t t t		CAPACITOR TER- MORE THAN 30 CROAMP.	†	1	1 1 1 1 1	! ! ! !
	1	*CAPACITOR BRIDGE TEST	ER	1	1	1	•
	060	1 .	UF	i n	!	1	; ! ;
	! 	ACTUAL	UF	1 	; 	·	ì
	1 080 1	THECK CAPACITANCE.	UF	! ! M	† †	t t	   
	1	I TEST 3 STORAGE CAPACITY NECTED BROUP. APPLY 400 FREE END ON INTER-CONNI BROUND ON CASE. LEAKAGE	DRS AS A CON- DOVDC BETWN ECT LEAD &		         	! ! ! ! ! ! ! ! ! ! ! ! ! ! ! !	1 . 1 1 1 1
	1 100 !			1	1 ! !	1	1 1 1
İ	ŧ #	I ACTUAL	UF	1 1	1	1 1	1 1 1 '.

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		CONTROL DOCUMENT # 72-10 1.DATE 86121				PAGE	_
STATION	IOP NO.	117.WORK TO BE ACCOMPLISHED	118.ME	CHI 19	"P"	120"0	**
	ŧ	FILTER TEST: APPLY 300 VDC BETWN "B" PIN & BROUND FOR NO MORE THAN 30 SEC THERE MUST BE NO SIGN OF BREAKDOWN.	1 #	1		! !	
		CHECK LEAKAGE BETWEEN EITHER TERMINAL AND CASE:		(     		     	-
	 	I ACTUAL MEGOHNS I *VACUUNTUBE VOLTMETER	•	1		} [	
	130	CAPACITANCE.		~   		! ! !	_
	<b>!</b> !	ACTUAL UF  **CAPACITOR BRIDGE TESTER	! !	1		1	
	i	RESISTOR TEST (29): MEASURE RESIST- I ANCE BETWN UPPER TERMINAL OF RESIST- I OR LEAD & CASE.		       		 	-
		I ACTUAL OHMS I *VACUUMTUBE VOLTMETER	\	[ 		1 1 1	
		TEST RESISTOR ASSY (45) MEASURE RE- SISTANCE BETWEEN RESISTOR LEADS.	   M 	- · ;     		†       	-
		ACTUALMEGOHMS	1	i i		l 	
		TEST EACH RESISTOR INDIVIDUALLY; MEASURE RESISTANCE BETWN RESISTOR TERMINALS.	! ! M !	         		       	-
!	<b>!</b>	ACTUALMEGOHMS	1	1		i i	
 	]	RECTIFIER TEST: USE HIGH VOLTAGE REBULATOR TO ADJUST VOLTAGE TO 5000V READ INVERSE VOLTAGE CURRENT.	M   M	- · ! } !		† †     	
1	1	ACTUALMEGOHNS	1 2 1	! !		! !	
		RAISE VOLTAGE UNTIL MILLIAMMETER SHOWS READING OF 100MA. FORWARD VOLTAGE DROP ACROSS RECTIFIER.	! ! M !	1		1 1 1 1	•
		I ACTUAL VOLTS I *DC VOLTAGE REGULATOR	1 !	1 ! !		 	
		READ VOLTAGE OVER A PERIOD OF 30 I SECONDS. I ACTUAL VOLTS	     M	• · [ {     		; ! !	-

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	. WORK	CONTROL DOCUMENT * 72-10 1.DATE 86121	PAGE 3	OF :	PAGES	. [ ]
ISTATIONIC	DP NG.		118.MECH	119"P	'   20 "Q "	1
	250	HIGH TENSION TRANSFORMER TEST: CHECK RESISTANCE BETWN THE 2 TERMINALS TO BURICH PRIMARY LEADS ARE ATTACHED.	;	;		1 1
		ACTUALOHN	[ [	! !	1	!
1 1	260	ADJUST FOR GAP & INTERNAL PRESSURE.	     <b>n</b>	; [ •	!	!!!!
		*ISNITION OUTPUT TESTER	, ! !	:   	,   	! !
i i	270	I REPAIR OR REPLACE AS NECESSARY.	i i ! M	   	-     	1
		TO CLINCH KNURLED FLANGE TO CASE, I TORQUE A NUT AGAINST DUTER WALL OF I CASE. I ACTUAL IN/LB	     M 	       	-	! ! !
		*TORQUE WRENCH.	! !	!	i !	17
		I ALL SCRENS & LOCKNUTS SHOULD BE I TORQUED. I ACTUALIN/LB I *TORQUE WRENCH		       	       	! ! !
	310	TEST IAW T.O. 8E1-8-9-3, PARA 2-36		     	\	1
		*TEST FIXTURE	!	: }	į	i
† † † † † † † † † † † † † † † † † † †		RAISE TRANSIFIER VOLTAGE REGULATOR UNTIL WAVE FORM DISPLAYED ON VOLTA- SCOPE SHOWS FIRST PEAK.		     	     	1 1
		ACTUALVOLTS	! 	! !	; ! - !	1
		THE FIRST HALF CYCLE SHOULD BE NEGA- TIVE & MUST SHOW AT LEAST 2 POSITIVE PEAKS & 2 NEGATIVE PEAKS WITHIN THE PERIOD OF 1 MILLISECOND.	<u>-</u>	†   	; ; ; ;	1 1 1
		TEST FIXTURE	, !	! 	İ	1
1 1	360	REASSEMBLE.	M	! !		1
		TEST STORAGE CAPACITOR; RAISE INPUT VOLTAGE TO 14V FOR NO MORE THAN 10 SECONDS. VALUE		,   	; ; ;	1   1   1   1   1   1   1   1   1   1
1		ACTUALVOLT	; {	• [ •	1	
1 1		TEST:   INPUT VOLTAGE		   	   	1

15.DISP	-16.PDN	CONTROL DOCUMENT * 72-10 1.DATE 86121			
STATION	IOP NO.	117.WORK TO BE ACCOMPLISHED	118.MEC	HI19"P	"   20 "Q
	1	INPUT CURRENT SPARK RATE	! !	! !	1
	1	ACTUALSR	į	i	i
	! ! !	INPUT VOLTAGE 24 I INPUT CURRENT I SPARK RATE	1 1 1 1	! ! !	1 1 1
	1 1 1	I ACTUALAMP ACTUALSR	1 1 1	1 [ ]	{ { 
	† † †	I INPUT VOLTAGE 29 I INPUT CURRENT I SPARK RATE	1 1 1	! ! !	1 1 1
	 	I ACTUALAMP ACTUALSR	1	1	ł !
	390   	I TIGHTEN HEX NUTS AT INPUT END, LARGE I NUT SHOULD BE TORQUED & THE 2 SMALL- FER NUTS.	•	1	! ! !
	1 1 1	ACTUAL FT/LBS ACTUAL IN/LB   *TORQUE WRENCH	1	† 	1   
	400	I SOLDER UNIT.	1	1	
	   410 	I TEST EXCITER FOR LEAKS USING A PROBE I WITH 14 PSIG. LEAKAGE.	     M	1	-     
	 	ACTUALCC   *VEECO LEAK DETECTOR	!		; ; ;
	420	I SUBMERGE EXCITER IN WATER HEATED TO I MINIMUM OF 49 DEG C (120 DEG F) FOR I 1 MINUTE.	i i n	1	1
	430   	CAS CHARSING: BAKE EXCITER 15 MIN.  THE 275 DEB F. THEN TURN ON VACUUM  THAT 275 DEB	1 1 M 1	1	 
W-41	440 	I PAINT.	     M		
	1 450 1	I BAKE IN OVEN FOR 1 HR AT A TEMP OF 1 230 DES F. OR AIR DRY.	     M	1	
	460	TEST: SET MICROMETER UNTIL SCALE READING INDICATES SPARK BAP OF 0.100 INCH. ADJUST NITROBEN INLET UNTIL GASE HOLDS STEADY.		1	

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	470	INPUT VOLTAGE 14 INPUT CURRENT SPARK RATE  ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE  ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE	18.MECH		1 20 ~ u ~	
	470	TEST: INPUT VOLTAGE 14 INPUT CURRENT SPARK RATE  ACTUAL PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE  ACTUAL AMP ACTUAL AMP ACTUAL PER 10 SEC INPUT CURRENT SPARK RATE  INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE				
	***************************************	INPUT VOLTAGE 14 INPUT CURRENT SPARK RATE  ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE  ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE			B   B	
		ACTUAL PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE  ACTUAL AMP ACTUAL PER 10 SEC  INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE			! ! ! ! ! ! ! !	
1 1 1 1 1 1 1 1 1 1	1 1 1 2 1	ACTUALPER 10 SEC  INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE		3 8 6 8 8 8	 	1 1 1 1 1
	1 2 1	INPUT CURRENT SPARK RATE	1 1 1	 	{ {	! !
          	1	ACTUAL			i .	1
t t t		ACTUALAMP ACTUALPER 10 SEC	   	   	t 1 !	1 1 1
	1	APPLY 24V INPUT CURRENT. OBTAIN ONE (1) OF THE FOLLOWING: METER READING	E	} } 	t } f	i   
1 1 1 1	1	72.5 78.0 83.0 87.5 91.5	1 1 1	t f t		1 1 1
1	1	ACTUAL	1 	i I	} 	1
! !		AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.		   	{   	1
1	t:	CERTIFY THAT THIS END ITEM HAS EXECUTED TO THE TOTAL CONTROL TO THE TOTAL CONTROL TO THE TEMPLE OF T	†   <b>A</b>	t 1	; t ; ;	!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!
     	- I	COMPLY WITH MADI 66-36, PARA 13  TYPE WORK PERFORMED	1 1 1 M	}   	{     	1 1 1
     		OPERATIONS COMPLETED & PAPERWORK PROCESSED.	! ! ! M	       	l ! ! !	1 1 1
t	i		i i	1	i i	1

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.ORIGZE		XXXXXXXXXXXXXXXXX I3.QUANTITY  4.PRUD SECTION/RUC  5.DATE     MTPCAP   U/O		16.DATE	ខលភាភា រិ
635E490 0. <b>m</b> 00:3	0001 ./DE9IGN	19.1TEM SERIAL NR	/OFT10N	ម	3014H   8061H
S.MISU	114.NUUN	ZEND ITEM NOUN IER, TEMP PAUL James MATEACZOUZO	Ûyo .		# # # # # # # # # # # # # # # # # # #
	MG.PDN/	II/.WORK TO BE ACCOMPLISHED	Late Till	H112"F"	120"6"
		72 10 ITEM 1 27717A			
	010	RECUIVE, IDENTIFY & AFFACH PAPERWORK	T n	· ] ·	
	17/	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.		; ; ; ;	
	030	INSPECTION (VISUAL)	1 71		
,	i	FERFORM FULL COOLING TUBE TEST FORE-TEST) (PARA 11-50) FUEL TEMP: DLG.			
	0(10   	PERFORM INSULATION RESISTANCE TEST   CPRE-TEST)   ACT	1 11		
i	040	SET.UP AMPLIFIER FOR PRESENT	<u></u>		1 1
	070	PERFORM OPEN THERMOCOUPLE PRE-1851.	i   n 		
idor	080	NULL VULTAGE COMPERSATION (PRE-TEST)	   M 		; ; ; ;;
	070	PERFORM POTENTIOMETER RANGE TEST	   M   · · · · · · · · · · · · · · · · · · ·		·
	100	STATIC DAIN FEBT (FRE-1EST) MICCIVOLTS DIFFERENTIAL OUTPUT	m		
	i I	I FROM NULL AGE (MA)	1. 1. 1	`	1 1

ISTATION!			
1		CONTROL DECUMENT & UC 1.DATE 89237	118.MECH119"P"[20"@"
i		+5 +10 -1 -5 -10	
		TEMPERATURE VO. ENGINE SPEED TEST CPRE (TEST) RURMAL SUMEDULE	
	ì	ACTERNATOR IS LIMITS FREQUENCY ACT	
		800 200 240 255	
		770 792 804	
 		025 040	
1 1	120	TEMPERATURE VS ENGINE SPEED RESET TEST (PRE-TEST)	
		ALTERNATOR IS LIMITS FREQUENCY ACT HZ	
	1	772	
1 1	!		
	130	ACCELERATION (STALL) RUSE( (PRE-TEST)	
; ; ;		ALTERNATOR MILITAGET VALVE FREQUENCY ACT HZ	
1	المدان عبيد د دام	770 804	13 4 0
	140	COMBAT RATING RESET	m   -
. 1	!	ALTERNATUR T 5 VALUES FREQUENCY AUT	

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SIAIIUN	IUP NU.	TIZ.WURK TO BE ACCOMPLISHED	TIB.MECH	19"  "  	120"U"
		770	i	i i	·
ا مستدر		1 804	1	1	1 1
!	150	I CHECK RELATIONSHIP OF 1 5 FLATS.	t	1	
	) }	2 1	1 11	;	
	1		de la		
	<b> </b>	1 (PRE TEST)	TH	i	i
		FEN DISPLACEMENT ACT	1	i i	i 1
	170	I FREUDENCY RESEARCE FEST (FRE-1201)		;	
				1	•
:	180	I SPEED DERIVATIVE TEST (THE TEST)	<u>i</u>		
i			) ii	1 1	
i	170	1 OBJAIN THE POSITIVE & ALGATIVE	1	;; [ ;	* *
i		1 GUTTUL MILLIAMPERE GWELLTG AT ALE	16	, , ,	,
;		F BROLL "LEFO" DETFINOU. F .1 OPG SWEEP ACT THE	•	i I	•
, ,		1 vs cha comate Aci		; ;	<b>!</b>
•		1 .5 CHS SETTING ACTMA	;	i	1
1		T SHEED DERIVATIVE WESHARDE (F.G.)	!		
Or .	<b>1</b>	1 RE 10.070	1 33	;	
	210	1 HIGH TEMPERATURE TEST.	i :	} ·	
i	Team	1	in	; ;	
	/\\ 220	T COLD TEMPERATURE TEST.			
		1 COLD TEIN ENTRICKE. TE.OT &	in	· .	<b>.</b>
	rens _	Description of the control of the co	1	l ;	
i 1	M30	FIROUGLESHOOF.	1 h	i i	
		The second of th	i	Ì	
i 1	240	1 IF ALL TESTS PASS MOVE TO STEP 33	1 11		
			1 00	, , }	
į.	250	DISASSEMBLE AS REQUIRED.	The March	1	
	1		1 1 T	! :	) <del></del>
i	260 \	CLEAN AS REQUIRED.	1	1	
		included pro->	1	i	
1	270	I INSPECT AS DIRECTED.	1		
i	man. t	L RESISTANCE ACT GHING I TORQUE CHECK ACT G2/IN	I M	} \$!	
· · · · · i	• • . •	The second companies and the contract and the contract of the		, 	·
1	200 +	FREPAIR OR REPLACE AS REQUIRED.	1 m	1	
	011	The contract of the contract o	1		
!	250	READSEMBLE SUB-ACSY'S AS DIRECTED.	1	i i	
	Con . A		M		
i	سهين	REASSEMBLE COMPONENTS AS DIRECTED.	i	i	
i	an't	1	ı m	1 1	

STATION	TUP NO.	117.WORK TO BE ACCOMPLISHED	118.MECH	112"1" 120"	1 1111
->	310	PERFORM FINAL ASSUMBLY AS DIRECTED.	1	120	لج د اد
		1- 5/104- 20-45-in (on every anit)	3 14 1 - Said	Par for	1
	1 320   	FINAL INSPECTION & PLREDRMANCE TESTS	ļ Ť n	1 1	1
	ŀ	COMPLETE & FORWARD AFTO 349 TO DATA	1 5		1
; ; ;	340 	I CLRIFY THAT THIS END THEM HAS BEEN OVERHAULED IAW T.G., TOTO, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.  OFERATIONS COMPLETE & PAPERWORK PROCESSED.	; ; ;		
	350 l	CUMPLY WITH MAUL 36-35, PARA 13 <	:  -   r:/		
1	, 1 1		Her	e carry	 
} 			5000	units	را درا ⊁
1			ens d	- 1	1
1		***		•	} }
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;	1	1	1	!	i

2. DH <del>IO</del> M	-XXXXXXX <del>TROO</del> NR	CONTROL DOCUMENT > JC 1.DATE 8823 ***********************************	TE SCHED 16.DATE CO
	УA 	I MICCA I 8	7094
	NUMBER 975-2	19.ITEM SERIAL NR	
J/V 1		/SERIESI11.STOCK NR   CHG 8   2925009921235FL	
e (o out de trapational	LIGHTET	ZEND TIEM NOUN JN EXCITER PAUL MATEACZ6U920	
		(1/.WORK ) G BL ACCOMPLISHED	118.MLCH117"F"120
		RECEIVE, IDENTITY & ATTACH PAPERWOR	K 1 1 1 1 1
		ALL REFERENCES ARE TO THE MADIC T.O ARD APPLICABLE PROCESS ORDERS, TECH DATA CONTAINS DETAILED NOTES, CAUT-10NG, WARNINGS, DIMENCIONS, AND TOLERANCES REQUIRING COMPLIANCE.	
a <b>b</b> a		FILMS CONTAIN PRECIOUS METALS, SEL FAST 65 4 FOR PROCESSING & CONTROL.	· · · · · · · · · · · · · · · · · · ·
- EM	030	THISTECTION (VISUALLY)	
	 	FUNCTIONAL TEST	m
		APPLIED ACTUAL ACTUAL ACTUAL VOLTAGE ENOUT SPARK DUITOT CORRENT RATE VOLTAGE	
; ;	<b> </b> 	14 N/A	
		24	
1		30 ) N/A	
	040 MIPEM	MOVE TO MACHINE SHOP TO REMOVE LID.	m   m   m   m   m   m   m   m   m   m
····	045	DISASSEMBLE	
• • •	;	CLEAN AS REQUIRED.	M
, m	055	INSPECT AS REQUIRED.	
	<b>0</b> 60	TEST TUBE ASSEMBLY.	

paragram and a second

15.DISP	-16 PDN/	CONTROL DOCUMENT > UC 1.DATE 80239			
STATION			10 - 11E   11	   TA	rzona Liinini
	065 	I TEST SPARK GAP. I ACTVDC .3 52	i . 11 <b>1</b> 1	i :	
	070	TEST RESISTOR AUSEMBLY   RESISTANCE ACTOHMS \$	]		
		TEST TRANSFORMER VIBRATOR ASSEMBLY   RESISTANCE ACT ORMS	,   M		
		A A A A A A A A A A A A A A A A A A A	0		
		TEST FILTER ASSEMBLY CONNECTOR INFUT PIN - HOUSING ACT	1505		rope
		FREMAIR OR REPLACE AS REQUIRED.	 		
	025	REASCEMBLY	; •• • • • • • • • • • • • • • • • • •		
	<b>.</b> <b>.</b>	(ORQUE:   NUT (37) ACT	1 11		
	105	TEST EXCITER ELECTRICALLY  APPLIED ACTUAL ACTUAL ACTUAL VOLTAGE INPUT SMARK SUTFUT CURRENT RATE VOLTAGE			
	; ; ;	14. N/A	: 	; ; ;	
	<b> </b> 	30 N/A	1 1	<b>t</b>	]
0-35		MOVE TO MIPIW (WELDING SHOP) TO HAVE LID WELDED.	! ! M	}	
	115	LEAK CHECK EXCITER.	l I m	] 	···*   
ملك يميد الكلي ودي الكلي والم	120	EVACUATE AND PURGE EXCITER. Over 1'm	b -	· · · · · · ·	••• •••   

		CONTROL DOCUMENT * JC 1.DATE 86239  112.WORK TO BE ACCOMPLISHED  1			   20%@#%
	•	I LEAK CHECK EXCITER (AROUND PLUC)	1		
		(USING THE WATER METHOD)	i m		
	1 125	PAINT		i	
	i 	1	] ii	i 	 
	1 130	I FEST EXCITER	1 1	; ;	<b>i</b>
	t 2 1 1	I APPLIED ACTUAL ACTUAL ACTUAL I VOLTAGE IRPUT SPARK OUTPUT CURRENT RATE VOLTAGE	6 1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	: :	
	; ; ;	1 14 3 3 3	<u> </u>	\$ !	<b>:</b> :
		24	1	!	· •
	i	1 30 N/A	1	: :	· ·
	<u>i</u> <u>i</u>	LEXCLIER 10-353975 2 (RADIDACTIVE)  I MAY BE REWORKED TO 10-353775 3  I CHUNRADIGACTIVE). IF DONE, REIDEN-  I TILY TO 10 353775 3 OR (106533773).  I RADIDACTIVE STICKER WILL NOT BE USED	n war	12 L	esp
. I M	1	( 1) REIDENTIFIED.	1 200		 
	i	I COMPLETE & FORWARD ACTO 349 TO DATA . I PROCESSING.	] 1 m	1	; ;
	155   155   	I CERTIFY THAT THIS END ITEM MAS I BEEN OVERHAULED IAW T.O., ICTO, I CURRENT REVISIONS, SUPPLEMENTS AND I APPLICABLE PROCESS ORDERS.	; m		
		OPERATIONS COMPLETE, PAPERWORK PRO-	1 n.	} · · · · · · · · · · · · · · · · · · ·	i
	1 - 165	COMPLY WITH MAUL 66-36, PARA 13			}
	1 1 1	I TYPL WORK FLRIORMED	M 	1 1 1	; ; ; ;
	1		1 1	1 1	: :
	1	1 	1	1	; ;
	1	1	1	; ;	<b>!</b> <b>!</b>
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2.0RIG/ 3 <mark>869</mark>	PROD NR - 4 <mark>A</mark>	**************************************		16.DATE	COMP
7 ART i		19.ITEM SERIAL NR 10/12.TECH BATA	Z01110N4		
		/SERIESI11.STOCK NR		U	<i>52.4-</i> 41
10.m190 	114.NOON   SOLENO   PLRRY/:   16.PON/	JEND TIEM NOUN ,		 	10.0%
,			1	1	1 ""
	i ! <del></del> .		1 17		1
		I ALL REFERENCES ARE TO BASIC T.O. AND I APPLICABLE PROCESS ORDERS, TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, I WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.	i fi I		
	030	DIBASSEMBLE SOLENOID ASSY.	l m	1	
	040	REPLACE VALVE ASSY (22)	1 7	i	1
	<b>050</b>	FRECORD QUANTITY & THICKNESS OF FURNOCES		···   ···	1
		RECORD QUANTITY & THICKRESS OF CHING (25) AND WASHERS (26) FOR REASCEMBLY PURPOSES.			i
	-070	T CLEAN PARTS AS REQUIRED.	i		;
	080	-MOP CFFARTS.	i m	1	1
	090	CHECK RESISTANCE OF COIL AGSEMBLY OHMS AND OHMS	1 11	1	;
	100	PERFORM DIELECTRIC TEST.	i i m	1	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
	110	REASSEMBLE SOLENOID ASSEMBLY	M		
•	1118	I IF NEW PIN IS REG. SEND ASSEMBLY TO FMTPIW FOR WELDING. I REG. NOT REG.	; ; ; ;		† †
	120   120	FEST AS REQUIRED.	1- · · · · · · · · · · · · · · · · · · ·	-     	i

5.DISC	-> woxck ( -16_PDN/	CONTROL DOCUMENT % JC 1.DATE G0237	TAUL 2	(13) 2 (3)	i hiili iii.
TATION	OF NO.	117.WORK TO BE ACCOMPLISHED	118.MECH	11775	i aonun
<b>,</b> i	130 	I AFIU FURM 349 CUMPLLIED & FURWARDED	l M	; 1	1
	140 	•	1 1 G 1	: :	
· i	1 a 567	COMPLY WITH MAGE 66-36, PARA 13 Fryne Work Performed	1		1
			i i	: 1 1	: :
, i j i	· ·		i i i	1	; ; ; ; ;
1 : 1 1		: 	 	:	[
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; ; 1			; ;	; ; ;	} 
i i i		 		; ;	; ; ; ; ; ;
; ;			1	} ! !	; ; ;
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; ! !	   	•	{   	; ! }	
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X · · · · ·

2.GRIG/PROD	) NR I	3.QUANTITY 14.PROD SECTION/RCC +5.DATE 1 MTPCAP / 870	SURED L		. U
7. ART NUME	DER			<u>-</u> ,	- 170
	SAUNZ	SERIESTI1.STOCK WK   1 GL1 2-06 3   2925011325027911 GNG 12		(3	/ 1
1.11	valona Olium	St.1 2 36 306 ERB TELT NOUN		<b>ය</b> ස ජ ස	ئان: د. <b>4</b> .
15.0100 16.	PD47	DONEL	DA 57	TROU	0
STATIUNIUL	NO. 1	17.WUNG (U BL ACCOMPLICHED	HU.MLUH	119"1"	12
i i	" i	F 10800281P3 2925007927904PL 35570A	i !		i i
	* 1 1	RECEIVED IDENTIFY & ATTACH PARENGURE	i n	1 w	1 -
022 11	; ;	ALL REFERENCES ARE TO THE EASIG T.O. AND APPETCABLE PROCESS ORDERS. THICH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRENCE COMPLIANCE.			1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
CLEA	im 1 Zab l	THEMO CONTAIN PRECIOUS METALS, SEE MAGE 65-4 FOR PROCESSING & CONTROL.	;	 	:
-	PON 1	RECEIVE EXCITER: REMOVE LID AND WELDO: RETURN TO MATRICA.	i i i	i 	i i
, , , , , , , , , , , , , , , , , , ,	,	O LUAGSEMBEE	i i i m	i i	;
	l 1	HOGSING ASSEMBLY, CHECK FLANGES MINIMUM HEIGHT ACT: INCH REWORK IAW 8E1 2-36 23 PARA 5-4.H. (6).	i ji		
 	1	REWORK: REQ HOT REQ	l	 	:
i	1 <b>0</b> 00	MILL HOUSING EDGE FOR HOUSING	, 		1
i mi	)70 i 1₽1₩ i	WELD EXTENSION ON THE HOUSING	i Im	i i	i i
i o i mi	i oe	WELD BRACKETS AND STUDS TO MODIFIED HOUSING. WHEN FINISHED MIFIW EILL RETURN BOX TO MIPCA.	i i m	!	1
. I C	90 1	MIPCA WILL MODILY EXCITER AS REG.		   	;

	* WORK (	CONTRUL DOCUMENT * JC 1.0ATE 66237	PAUC 2	- Бі" з	VAULS!
,	-16.PDN/- TOP NO.		L18.MECH	117"5"	120"4"
		*TEST HOUSING AND TRANSFURMER AGGY. (60); MEASURE PRIMARY AND SUCONDARY RESISTANCE. GREENWIRE WHITEWIRE ACT ORMS BROWNWIRE RED WIRE ACT ORMS * ORMETER	\$	1 1 1 1	
	1 110	FREST ELECTRON TUBE ACSY. (20) (26) INVERSE COURTN'S FLUX ACT MA GPERATING CURRENT ACT MA FREST SECTION TUBE TEST OUT	 		
		*TEGT REGISTOR AGGT. (44)   RESISTANCE		i ·	
1	130	TURBUE VAULEO:   SCREWS (58) 2	i I m		
	TE E	RUTG			
	1 140 1	WHEN COMPRESSING CHPACIFOR ASSEMBLY	i i i	1	U-41
		CUP GOES TO MACH. SHOP TO BE CUT OFF AT SCRIBED LINE.		 	
155_	; ; ;	THE BOX MAY HAVE TO GO TO HIPTW  AFTER ANY ONE PROCEDURE TO HAVE THE PLATE ON THE VIBRATOR AUST.  (C1) WELDED TO THE PARTITION. AT THIS TIME THE FILTER ASSY. CONNECTOR AND CUP COULD BE WELDED TO THE HOUSING. EXCITER WILL THEN BE RETURNED TO MIPCA FOR TESTING.	 	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	
COMBIN	160 MIFEA	EXCITER WILL BL TESTED TAW		• • • • • • • • • • • • • • • • • • •	
` ` ` ` ` ` ` `	1 120 T i	"BEFORE" COVER TEST:	1 17 1		
ASS	1	MAIN  14 VDCAUT SZR  24 VDCACT SZRACT OUTPUT  30 VDCACT SZR	1	1	
,	1 minuw	FINISH PACKING EXCITER THEN SEND   WITH COVER TO MITTOUR FOR   CONTINUED	l l M	;	1 1

DIMITOR			1:8.%ECH19"F"12	ortur
and and the second second		WELDING OF COVER TO HOUSING. MTTIW   WILL SEND BACK TO MTPCA		
	LATIFUA	TEST FOR LEAKAGE, EVACUATE, AND   PURGE IAW 8E1 2-36-3.	1 1 1	
	•	FORQUE PLUG (13): FACT: 10/LB		•
	1 - 200 1 - 200 1 1	I TEST EXCITER "AFTER" TEST  A78 I 90 VAC ACT GAR I 115 VAC HOT GAR ACT GUIDUT I 120 VAC ACT GAR		
	i i i i i i i i i i i i i i i i i i i	MAIN LA VOU AUT SZR LA VOU ACT SZR LA VOU ACT SZR LAO VOU ACT SZR		
	1 1 1 1	TEST UCTOG 11-4700-1 FECTER AND FIT-9800 SPARR GAP ASSY. TESTER. FIRED FIRED FIRED FARING STOPS FACT: KR		
	1 220	LULETA AS REQUIRED		
	230	PAINT AS REQUIRED		
	; ; ;	MARK NEW PART NUMBER 10 397625 1 (GE 10605281P5), A LETTER R IN REV BLUCK, AND ORIGINAL SERIAL NUMBER, CURRENT, VOLTAGE, AND TYPE LETTERS ON NEW IDENT. PLATE. DO NOT APPLY RADIOACTIVE WARNING PLATE AS WARNING NO LONGER APPLIES. (AS PER TOTO) INSTALL IDENT. PLATES.		
Transition of the community of	1	I I CERTIFY THAT THIS END ITEM HAS I BEEN OVERHAULED IAW 1.0., 1010, I CURRENT REVISIONS, SUPPLEMENTS, AND I APPLICABLE PROCESS ORDERS.		
ng nga i ng ng nga		OPERATIONS COMPLETED & PAPERWORK FORWARDED.		
· ·		COMPLY WITH MAD1 65-35, PARA 13   TYPE WORK PERFORMED		

2.ORIG/F	PROD NR	13.QUANTITY 14.PROD SECTION/ROC 15.DATE 1 MTPCAP 1 890	SCHED 16.		10
7., ART 1		19.1TEM SERIAL NR 18/12.TECH DATA 1 PO MAT87-16		** *** ** ** ** ** ** ** ** ** ** ** **	بمها
11 33 3	./DESIGN. 3/11A	// PO MATG/ 1 /SERIEST11.STOCK NR		8330611	W.
U21M181	14.ROUR   IURLII   JUNNIN	VERD TIEM NOUN TOLL 200 100 ON EXCITER PACT LARY WAS GS/MATEAC/65/20	1 AR区	299 <b>1.41</b> 	;
SGATIUN:	16.PDN/ OP NO.			7"I" 120"&"	:
		F/N 3/8205 FP/N 10-18/860-1 FM HP/A 98001(A) (1) FC/N 49/11A FF/N 10 61/060 1 F(SUPERCEDES 10-18/860-1) FS/N 29/25011318/61RV			· · · · · · · · · · · · · · · · · · ·
₩ 45 Î	010	RECEIVE, IDENTIFY & ATCH PAPERWORK.		1	1
· · · · · · · · · · · · · · · · · · ·		I ALL REFERENCES ARE TO THE BASIC T.O. I AND APPLICABLE PROCESS ORDERS. FECH I DATA CONTAINS BETAILED NOTES, I CAUTIONS, WARRINGS, DIMENSIONS AND I TOLERANCES REQUIRING COMPLIANCE.			i i i
	<i>FC1F</i> = 020	I MOVE TO MACHINE SHOP & REMOVE LID.			
	U30	DISASSEMBLE.		i i	i i
	040	CLEAN AS REQUIRED.			i i
	050	INSPECT.	1		
1		I INSPECT HOUSING ASSEMBLY RETORT I ACTIRCH. I REPLACED NEW YES NO	m l	1	; ;
W 41		MOVE UNDERSIZE HOUSINGS TO WELDING   FOR EXTENSION STRIPS	M		i i
· · · · · · · · · · · · · · · · · · ·		MEASURE RESIDEATED OF FILTER, DE-	M		1
·		I *OHMMETER			i
0-35 l	MIPIW	WELD FILTER AND CORNECTORS.  Continued)	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	<b>\$</b> <b>i</b>	1 i

NOITA	-16.PDN/- 10P_NU.	117.WORK TO BE ACCOMPLISHED	18.MEUH	149"1"	เลอานาไ
······································		REQ:NOT_REQ:	1	1	i :
and the second second		MEASURE CAPACITANCE BETWEEN INPUT			i i i
	• •	ACTUF *CAPACITOR ANALYZER*	; ;	; ;	
	1 070 :	I CHECK INSULATION RESISTANCE DETUCEN	i fi	\$ \$ \$	
,	i i	ACT MEGUMMS  ***AOO VOLT MEGGER* // // // // // // // // // // // //	1 13	550	
· · · · · · · · · · · · · · · · · · ·		(TRANSFORMER) MEASURE FRIMARY RESIS	; ;	i	
	i I	AUTOBM . +OBMACTERX	1	ė i	1
		MEASURE SECONDARY RESISTANCE SETWEEN FRANSFORMER.		i i	
		ACTUIIT	1	1	
i	i	CHECK CAMACITANCE OF CAMADITOR, FUN 10-107202 KCAMACITOR ANALYZER* ACT: OF	i i m i	i	, , , , , ,
	i	CAPACITANCE BETWEEN NO 1 LEAD AND GROUND GF	i i m		··· • · · ·
	1	UAPACITANCE BETWELN NO 2 LLAD AND   GROUND   UF	1		
<b>-</b>	ł	CAPACITANCE BETWEEN NO 3 & 5 LEAD  ACTUF	   M	i	;
	i	CAPACITANCE BETWELN RU 4 & 5 LEAD  ACTUF	1 h 23/1	remove	     =
	170     170   	APPLIED VOLTAGE BETWELN NO 1 LEAD   & GROUND   VDC   APPLIED VOLTAGE BLIWEEN NO 2 LEAD   & GROUND	!		40.1
	i i	ACT	1 1 1	1 1	1 1
	1	ACTITED VOLTAGE BLIWLEN NO 4 & 5   LEAD	1	 	

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	16.PDM/	CORTROL DUCUMENT A 72-10 1.DATE 07040- 117.WORK TO BE ACCOMPLISHED	lia.nECH	_	i a felicio di Sa Il mangani El mangani
	<del></del>	THERE SHALL BE NO VOLTAGE BRK ON OR FLASHOVER OF ANY SECTION DURING A 15 SECOND PERIOD OF APPLIED VOLTAGE.    *JET IGNITION COMPONENT SET*	1	1	i
· • • • • • • • • • • • • • • • • • • •		I MEASURE RESISTANCE OF RESISTOR (6) & FRESISTORS (7) WHICH TOOLTHER MAKE OF RESISTOR ASSY. RESISTANCE READING FOR RESISTANCE READING FOR RESISTANCE (7)		i	
i :		l AU: Unif L AU: Unif		1	1
, , ,	4.0	POLITICE EXEANDOUN FOR STAIR UNIT THOIL  ACT VOC	; ; ; ;		# : :
i		F WOLT TONITION COMPONENT TEST OLIVERS	1		
)		CHECK RECYCLING ASSEMBLY FOR CORT CARROLLY OF RECYTLIERO. (A)	1	1	; ; ; ,
		l de manuscritture (1956), del 1971 (M. 1972). Les este de les este	1 "	1 1	i (
; ;		FORECK COIL FOR CONTINUITY BETWEEN EAR TERMINAL & THE CONTACT FOR IN THE FORECKER.  1. **COMMETER***  1. **COMMETER***  1. **COMMETER***  1. **COMMETER**  1. *	1 1 1 1	from	
,		REPAIR OR REPLACE AS RECESSARY AND VIBRATUR SHALL BE REPLACED AT EACH LURITION EXCITER OVERHAUL.			
· · · · · · · · · · · · · · · · · · ·	230	RUASSEMBLE		1	i !
		I VACUUM DRY IGN EXCITER FOR PERIOD OF 4 HRS AT 120 DEG F AT ONE INCH MER I CURY ADSOLUTE PREUG MAX.			
, ,			i i ii	1	1
, , , , , , , , , , , , , , , , , , ,		BAKE IGNITION EXCITED AS FOLLOWS:		1 " "	<b>4</b>
! !		200 DEG F/1 HR.	1	1	! !
, 1		1 240 DEG F/1 HR.			•
		300 DCF F/2 HRS.	1	 	1
ე—პნ I	270	MOVE TO WELDING GROP & WELD LID TO FEXCITER & PERFORM LEAK TEST.	i i m	(2-	-)
; ; ;	300	. I CLOSE VACUUM LINE & PRESSURIZE TON I ITION EXCITER TO IS POT BASE WITH I DRY AIR OR NITROSER HAVING A DEW	1	 	; ;

EXECUTE:	. 1 Z - MON Z	CONTROL DOCUMENT * 72-10 1.0ATE 87045			
CONTRACTON	OF NO.	117.WORK TO BE ACCOMPLISHED	118.MECH	119"P"	20"@"
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		I REQ NOT REQ	i I Mi I	• 	
: WW-41 ! !	320 Miria	FAIRT IONITION EXCITER. APPLY LAC- FOURR, FLD SPEC TT-L 32, TO A FILM FINITENESS OF THE THEORY	: !	• · · ·	
1	i www.	FALLOW TO DRY FOR 40 MINUTES IN DUST- FREE ATMOSPHERE. IF PAINT BLISTERS/ FSTRIP FOROUS AREA. CLEAN & REPAINT.		 	· · · · · · · · · · · · · · · · · · ·
i	i	I TEST: CHECK CONTINUITY BETWEEN TWO I DUTPUT TERMINALS OF ION. EXCITER.	1 17	i i	
		TEST: APPLIED VOLTAGE (VDC) 14.0 FINDUT CURRENT FORAKK RATE (PER SECOND) FOUTPUT VOLTAGE (VOLTS) FOUTPUT VOLTAGE (VOLTS) FOUTPUT VOLTAGE (VOLTS) FOUTPUT VOLTAGE (VOLTS) FOUTPUT VOLTAGE (VOLTS) FOUTPUT VOLTAGE (VDC) FOUTPUT FOUTPUT VOLTAGE (VDC) FOUTPUT FOUTFUT FOUTPUT FOUTFUT F	; 1 m 1 1	1 1 1 1	
i ;	 	APPLIED VOLTAGE 24   THEOT CURRENT   SPARK RATE   OUTPUT VOLTAGE   ACT:AMPS MAX	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	: : : :	
1 ; ; ; ;	1 4 5 1 1	ALT: SZR  ACT: VOLTO APPLIED VOLTAGE 30 I INPUT CURRENT I GPARK RATE I OUTPUT VOLTAGE ACT VDC	394	96	
i i	1	ACT:VOLTS	1 6.7	Þ 9	1
† †	i 	ACT:AMPS MAX.		1	1
	   360 	I AFTO 349 COMPLETE & FORWARDLD TO I DATA AUTOMATION.	m	1	
; · · · · · · · · · · · · · · · · · · ·	370   370 	I I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TOTO, LURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M   M		1
1	1 380 1	OPERATIONS COMPLETED AND PAPERWORK   PROCESSED	   11		

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TYPE WORK PERFORMED  13.MELHIPMPN 2001  SOS COMPLY WITH MADI 66-36, PARA 13  TYPE WORK PERFORMED  13.MELHIPMPN 2001  15.MELHIPMPN 2001  16.MELHIPMPN 2001  17.MELHIPMPN 2001  18.MELHIPM	S.DISH-18.PDF FATIONION NO.	1/2.WORK TO BE ACCOMPLISHED	ila.mEci	H119"F"	120"u
TYPE WORK PERFORMED					} :
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		I3.QUANTITY 14.PROD SEC	TION/ROC IS.DATE		6.DATE	COMP 1
	S. E. F. B. A. D. PT. PT.	I MIPCA				···· i
2., ART	ROPUER	19.ITEM SERIAL NR	- 18712.1ECH DATA - 1-8E1-8-22-3 - 1-CHG-13	(VULTIONA		. 282H   
	L/DESIGN A1/402D	ZSERIES(11.STOCK NR	1			; ;
	1/1/8/11/1	ZEND IN MINOUN ON EXCITER PA UMZMATEACZSUZEO	WENDEL	HAL	A KIK	! ! <b>5</b>
P74		NON CZ				1 1
10/507 10/307 507512	990 3	27250107768666E 612 27250107768666N 475 27250107768666E 500	<u>alia</u>			
	iostpika 1811 alis	117.WORK TO BE ACCOMPLE	STREET	i 18. metal	1523°	i i i www.tathi.
	1	1 1071.			1	i ' i
	i i i	T EXCITERS 6872000, 689 I ARE WORKED THE SAME E I IN DIFFERENCE DATA SH I T.O.	MULTI AS NOTED	1	} } }	
	1 1 000 !	FORMELETE AF FORM 1834 FOUR TIZED-ALC FARE SU		<u> </u>	i	i i
w mo	1 010 1	KLULIVE, IDENII, Y & A	TTACH PARLKWORK	<u>-</u> -	i 1	i i
		COLUMNIC PROCESS    DATA CONTAINS DETAILE   CAUTIONS, WARNINGS, D   TOLERANCES REQUIRING	OMENDIONO & COMPLIANCE.	1 6:		
	020   	I TEST EXCITER: APPLIE 17, INPUT PREQUENCY IMPUT CURRENT (AMPS M I RATE (SPARK PER MIN) I OUTPUT VOLTAGE (VOLTE	(HERTZ)-400, NAX) -3, SPARK			
	† ; ; ;	I SIDE #1 I AMPS I SPARK RATE I OUTPUT VOLTAGE	60	3906	1	
	! ! !	SIDE #2   AMPS   SPARK RATE   OUTPUT VOLTAGE	<u>-</u>		d/+ - cm	dreat me
	1 1	I AN EXCITER FAILING AN BE DISASSEMBLED ONLY REQUIRED TO LOCATE AN CAUSES OF MALFUNCTION AS REQUIRED TO ACCOMP	TO THE EXTENT D CORRECT FARD LIMITED	1		

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DIGH	to PONZ-	CONTROL DOCUMENT * JC 1.0A:E GU204		-	1
ATTON	IOP NO.	117.WORK TO BE ACCOMPLISHED		119350 1	120"9"1 . :
		AND/OR ELECTRICAL REPAIR.	1	1	;
gare displayeller	040	DISASSEMBLE	13 45 pm		1
	;   050 	CLEAN AS KEQUIRED	 	! !! !	1 
	I აგა i	i inspicer.	i	i i	
	l 670 I	L CHECK COMPONENTS PARTS AS NECLESCARY/	Test e	941/2	3552
	200	REPAIR OR REPLACE NO MICHOGARY.	  - 	; oc*.	
	• •	FIT REQUIRED: KOUTE HOUSING FAN FIO 383721 & COVER FAN 10-381355 FOR FEATING. REQ NOT REQ	n		
		E ENGURE DEPAIL OF CONTACT HEAD IN		<b>∮</b> (	
	i !	ACTUALINVII	1 : :	1	i i
	! 1	FARTE AN EVEN CUATERS OF RIV SILE FORE RUBBER ADRESIVE. ALLOW ASSEM- FERT TO CURE FOR 24 HRS MER AT ROUM FERT.		i i i	
	1 279 1 279	REASSEMBLE.	: :	i ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' '	
و در م		GOLDER EXCITER.	;	1	1
·	1 310   310 	PRESSURIZE EXCITER WITH 18 FOI NITROGEN. SUBMERCE EXCITER IN WATER HEATED TO A MINERAL OF 1.0 200. F. I WITH SUFFICIENT AROUN, OF WELLIAGE AGENT. FOR MINIBUM OF 1 DEGOL.	1		
		CLOSE OVEN AND HEAT TORTTON EXCITER 1 TO 210 DEGF TO 230 DEG F FOR 1/2 HR.	1 71	1	
	1	EVACUATE IGNITON EXCITER TO 1 INCH   MERCURY & CONTINUE BAKING FOR 4 TO   12 HRS MINIMUM.	i I	1	
TO THE TOTAL PROPERTY.	l 1	CLOSE VACUUM LINE & PRESSURIZE IGNI- FION EXCITER TO 15 PSIG WITH DRY ARR FOR NITROGEN HAVING A DEW POINT OF F-65 DEG F.	i1   i1	1	
		REMOVE ISNITION EXCITER WITH STOP-   COCK FROM OVER & ALLOW TO COOL TO   CONTINUED)			i

ROOM TEMP  410 SEAL PLOUS INTERRESE EXCITER IN WATER MAINTAINED AT A TEMPERATURE OF 180 R 10 200 DEED, F. POR 1 DINUTE.  420 FEST EXCITERS AFPLIED VOLTAME (VAL) -19, 1980 TEMPERATURE (VAL) -20, 10 construct (MAIX 2) -400, 10 construct (MAIX 2) -400, 10 construct (MAIX 2) -400, 10 construct (MAIX 2) -400, 10 construct (MAIX 2) -400, 10 construct (MAIX 2) -400, 10 construct (MAIX 2) -400 c	INGLIA	OP NO. I	CONTROL DOCUMENT * JC 1.0A/E 88204 17.WORK TO BE ACCOMPLISHED	118.KECH	119 P	rzonu
410 SEAL PLUG & IMMERCE EXCITER IN WATER  MAINTAINED AT A TEMPERATURE 0 109  10 200 DEEG F. POR I THAN E.  420 TEST EXCITER; ANTERED VOLTAGE (VAL)  -19, INTUI REQUERCY (MER 2) - 400, IN  FORT CORRECT (AMIS MAX) - 3, STANK  RATE COLAR TER MIR.  DOTHOT VOLTAGE (VOCTO)  JONE R.  ANTO  OTHER ATT.  OUTTOT VOLTAGE  OTHER ATT.  OUTTOT VOLTAGE  OTHER ATT.  OUTTOT VOLTAGE  10 CORRECT THAN THIS END TORWARDLD IN  AND ACTED TORMAN ANTERED  COUNTRY THAN THIS END TIEM MAS  SEER OVERHAULED IAW T.O., TO:O IN  CONNECT REVISIONS, SUPPLEMENTS & APPLICABLE PROJECT CHORES.  400 OPERATORIC COMPLETED AND PAPERWORK  FROGESCHE PROJECT CHORES.  400 OPERATORIC COMPLETED AND PAPERWORK  FROGESCHE TO SERVICLABLE TAG.  400 COMPLETE AT FORM 1504 AND PAPERWORK  TYPE WORK PERFORMED  400 COMPLETE AT FORM 1504 AND AND TORM  TYPE WORK PERFORMED  400 COMPLETE AT FORM 1504 AND AND TORM  TYPE WORK PERFORMED  400 COMPLETE AT FORM 1504 AND AND TORM  TYPE WORK PERFORMED  400 COMPLETE AT FORM 1504 AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  ADD TABLE TAG TAG AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  ADD TORMICS OF A FORM 1504 AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  ADD TORMICS OF A FORM 1504 AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  ADD TORMICS OF A FORM 1504 AND AND TORM  TORMICS OF A FORM 1504 AND AND TORM  ADD TORME TORM 1504 AND TORM  TORMICS OF A FORM 1504 AND TORM  ADD TORME TORM 1504 AND TORM  TORMICS OF A FORM 1504 AND TORM  ADD TORMICS OF TORMICS OF TORMICS OF TORMAN 150 AND TORM  TORMICS OF TORMICS OF TORMAN 150 AND TORM  ADD TORME TORMICS OF TORMAN 150 AND TORM  TORMICS OF TORMAN 150 AND TORMAN 15			ROOM TEMP	i	ì	i · · ·
### TEGST EXCITER; ACTELED VOLTAGE (VM.)  -19, INTO TREDDERCH (RENIZ) - 400, I m  TOMPH CORRECT (AMIC MAX) - 3, STARK  RATE (GRANK TER MAR)  GOTPOT VOLTAGE (VOLTO)  JOHN MAIL  GOTPOT VOLTAGE		}	SEAL PLUG & IMMERCE EXCITER IN WATER MAINTAINED AT A TEMPERATURE OF 100 TO 200 DEB. F. FOR I DIMUTE.	i	1 1 1 4 1	1
SPARK RATE GOTTOT VOLTAGE  AUG FAIRT  RATEA  4.30 FAIRT THAT THIS END TIEM HAD FILLED ANTOHORS SUPPLEMENTS & ECHA OVERHABLED TAW T.O., TOTO IM ECHARM REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.  4.00 FOREATIONS COMPLETED AND PAPERWORK FIROLOGIED  AND HAVY FORM GONAV 4790/113 OR AFTERM AFTER VS FILLED DOT COMPLETELY ARC TAPLED TO SERVICLABLE TAG.  4.00 COMPLY WITH MAGI 63-33, PARA 13  TYPE WORK PERFORMED  4.70 COMPLETE AF FORM 1534 AND AFTO FORM 1 205 ( IF APPLICABLE) AND AND AND FORM 1 205 ( IF APPLICABLE) AND AND AND AND AND AND AND AND AND AND	; ; ; ;	i	TEST EXCITER: APPLIED VOLTAGE (VAL)  -19, INPUT EREQUERUT (BLR) - 400,  INPUT CURRERT (AMES MAX) - 3, SPARK  RATE (SPARK FER MIN)  BOTPOT VOLTAGE (VCLTS)  SUBL AI  AMES  SPARK NATE			
AGO I GETTO FORM GAP CONFLETED & FORWARDED  1. LACA AGTORATION  1.			OFFISION INTO	1	1	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
430 FATTO FORM 342 CONFLETED & FORWARDLO  1. LACE AGTORAL COR		រឺជាមេប៉ា		1 1 11		1
TYPE WORK PERFORMED  TYPE WORK PERFORMED  TYPE TO COMPLETE AF FORM 1034 AND AND AND TO TOM  TYPE TO COMPLETE AF FORM 1034 AND AND AND TO TOM  TYPE TO COMPLETE AF FORM 1034 AND AND AND AND AND AND AND AND AND AND	i	ing sign of the si	ANTO FORM 347 COMPLEND & PONWARDLD ( E. L. JACA AGEGRALICA)	i M	•	
TREGULOUSED   M   M   MANY FORM GENAV 4790/113 OR AL LORG   M   AFTO 75 FILLED DOT COMPLETEL? AND   M   GRAPLED TO SERVICEABLE TAG.   M   M   M   M   M   M   M   M   M	· · · · · · · · · · · · · · · · · · ·	-, , ⊖ ; 	: 1 CERTIET THAT THIS END ITEM MAS BELN OVERHAULED IAW T.O., TOTO CURRERT REVISIONS, SUPPLEMENTS &	i i		i
AFIG 75 FILLED DOT COMPLETEL? AND A STAPLED TO SERVICEABLE TAG.  405   COMPLY WITH MAG1 66-36, CARA 13   M   TYPE WORK PERFORMED   M   TYPE WORK PERFORMED   M   TO COMPLETE AF FORM 1034 ARD ALTO LORM   205 ( IF APPLICABLE) ARD ANNOTATE   M   TOUTON ON THE AF FORM 1074 SERVICE   ABULE TAG TAW ARM 400 1 VOL 11/00-ALC	; ; ;	Archist i		i	; ·	i i
TYPE WORK PERFORMED	i 1	400 i	AFTO 75 FILLED OUT COMPLETELY AND		1	i
470   COMPLETE AF FORM 1U3- ARD AFTO FURM	; ;	435 I	COMPLY WITH MACT 63-33, MARA 13			; ;
1 205 ( IF APPLICABLE) AND ANNOTATE   1 7   1   1   1   1   1   1   1   1			TYPE WORK PERFORMED		i i	i
	i	÷70	205 ( IF APPLICABLE) AND ANNOTATE   TOD/TON ON THE AC FORM 1574 SERVICE     ASSET TAG TAW AND 400 1 VOL 17/00-ALC	1 3	; ; ; ;	
	:	·		 	 	1
		,	, 			i

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*	****	CONTROL DOCUMENT * JC 1.DATE 89045 ************************************			
	RUU NR 6/234	. Administration of Market		16.DATE	CUMI
1 41540	(M)	I FO MAY87-16	/OFTION		# d 1965
1 TF 33 -5	5/9	/SERIES111.3 FOCK NR   8E1-8-9-3   2925004637319KVI CHG 10			6135
113.M190	14.NOUN I IGNITI	/END 1TEM NOUN   SE1-8-9-3-1 /END 1TEM NOUN   CHG 3 ON EXCITER PACI DS/MATEAC/65920			8152
115.0198	-16.PDN/		I18.MEC	 ዘ <b>! 1</b> ሃ " ጮ "	120"
† · · · · · · · · · · · · · · · · · · ·		(TF33 P5/7)			
		NOTE NOTE MUDIFY ABOVE P/N EXCITEK ASSEMBLIES I IAW 1.0. 8E1-8-9-3-1 (OVERHAUL CONFIGURATION CHANGE DATA)	! ! !	1	i ! !
W-43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	   M		
	1	ALL REFERENCES ARE TO THE BASIC (.O. I & APPLICABLE PROCESS ORDERS. TECH I DATA CONTAINS DETAILED NOTES, I CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.		1	1
1	020	DISASSEMBLE. Transform	er che	8 e <u>9</u>	1 2 2 4 4
	030	CLEAN AS REGUTRES	M		
! !	040	INSPECT AS REQUIRED.	i i m		! !
	0.5	PLATING AS REA	i m	1	1
	050	CAPACITOR TEST: TRIGGER CAPACITOR, APPLY 5000VDC BETWEEN CAPACITOR TER- MINAL & GROUND FOR NOT MORE THAN 30 SECONDS. LEAKAGE.	)   M 	1	1 1 1
in. toal	<i>)</i>	ACTUAL MICKOAMP.  *CAPACIFOR BRIDGE TESTER		1	   
<b>5</b> /	060	CHECK CAPACITANCE.  ACTUAL UF	i m		!
Y	070	TEST BREAKER CAPACITOR BY APPLYING  600VDC BEIWN TERMINAL & GROUND FOR NOT MORE THAN 30 SECONDS.	i		     

CAECO5	* WORK	CONTROL DOCUMENT * JC 1.DATE 87045	PAGE 2	OF 7	PAGES
	-16.PDN/ IOP NO. !		118.MECH	19"P"	120"Q"
)	! !	I ACTUAL MICROAMP		,   	! !
	080	I CHECK CAPACITANCE.	1	! !	1
!	1	ACTUAL UF	+ 4	1 	1 1
	 	I TEST 3 STORAGE CAPACITORS AS A CUN- I NECTED GROUP. APPLY 4000VDC BETWN I FREE END ON INTER-CONNECT LEAD & I GROUND ON CASE. LEAKAGE	M		
		I ACTUAL MICROAMP	† !	ł	ł t
	100	CHECK CAPACITANCE AT SAME TERMINAL		   	
!	!	ACTUAL UF	)   	[	; ! !
		FILTER TEST: APPLY 300 VDC BETWN "B" I PIN & GROUND FOR NO MORE THAN 30 SEC I THERE MUST BE NO SIGN OF BREAKDOWN.			! ! !
	120	CHECK LEAKAGE BETWEEN EITHEK I TERMINAL AND CASE:	   M	   	
!		I. I ACTUAL MEGOHMS I *VACUUMTUBE VOLTMEILR	1	{ 	! ! !
/.	130	CAPACITANCE.		1	!
		ACTUAL UF I *CAPACITOR BRIDGE FESTER	i M ! !	! ! }	1
i	140	RESISTOR TEST (27): MEASURE RESIST- I ANCE BETWN UPPER TERMINAL OF RESIST- I OR LEAD & CASE.			
: : :	 	ACTUAL OHMS  *VACUUNTUBE VOLTMETER	1	 	1 1 1
(	150	TEST EACH RESISTOR INDIVIDUALLY.	m	; ! }	
į		ACTUAL OHMS		i I	†
		ACTUAL OHMS	1	; !	
1	160	TEST RESISTOR ASSY (45) MEASURE RESISTOR LEADS.	! M	; ; ;	-
!	;			!	1
, 	} }	ACTUAL MEGOHMS	<b>j</b>	, } !	,   
	<b>]</b>	TEST EACH RESISTOR INDIVIDUALLY; MEASURE RESISTANCE BETWN RESISTOR TERMINALS.	1   M	;	! !

	EC05	* WORK (	CONTROL DOCUMENT * JC 1.DATE 89045	PAGE 3	OF 7	PAGES
STA	ALION	OP NO.		18.MECH	19"P"	20"Q"
) )		   	ACTUAL MEGOHMS	 	1	 
### # · · · · · ·		180	RECTIFIER (EST: USE HIGH VOL(AGE REGULATOR TO ADJUST VOLTAGE TO 5000V READ INVERSE VOLTAGE CURRENT.  ACTUAL *TEST FIXTURE			
<b>***</b> ****			I RAISE VOLTAGE UNITE MILLIAMMETER		! ! ! ! !	
kra man ya	<u></u> !	 	VIBRATOR OVERHAUL: COIL TEST: MEASURE RESISTANCE BETWEEN SECONDARY OUTPUT TERMINAL & GROUND. ACT: OHMS **VACUUMTUBE VOLTMETER	! M ! M !		
· ·		200   	VIBRATOR TEST:	! ! M !		     
		 	I INTERMEDIATE VOLTAGE 2400 I SPARK RATE. I ACTUAL SPM I INTERMEDIATE VOLTAGE 2500 I SPARK RATE I ACTUAL SPM	\$ \$ \$ \$ \$ \$ \$	{	t 1 1 1
			I INTERMEDIATE VOLTAGE 2500 I SPARK RATE I	, 1 1 1	1 1 1	† † †
		       	INTERMEDIATE VOLTAGE 2700 LOPARK RATE L ACTUAL SPM L *VOLTASCOPE			 
	/		PRIMARY WAVE FORM FOR AN INPUT RANGE MUST NOT EXCEED AMP & VARIATIONS BETWN PEAKS. ACT VOLIS	1 M	1 1 1	! ! ! !
)		 	I ACTUAL AMP ACTUAL AMP I *VOLTAGE REBULATOR	 	 	 
		t	PRIMARY WAVE FORM FOR AN INPUT RANGE NUST NOT EXCEED AMP & VARIATIONS BETWN PEAKS.	   M	} }	 

15.DISP-16.	.PDN/-				
STATIONIOP	NO.   	17.WORK TO BE ACCOMPLISHED	118.MECH	19"P" 	(20"6 
) !	1	ACT VOLTS	1	i 1	1 }
i	ì	ACTUAL AMP ACTUAL AMP	1	· 	!
	1 1 1	DISCHARGER TUBE TEST: RAISE VOLTAGE SOURCE SLOWLY TO MAX OF 5000V. IF TUBE BREAKS DOWN AT LEVEL BELOW 4100 VOLTS, REPLACE. IF IT BREAKS DOWN BETWN 4100 & 5000V, OR IF IT DOES NOT BREAK DOWN AT ALL, IT IS A GOOD TUBE.  REPLACED	t		; ; ; ; ;
<b>!</b>	!	NOT REPLACED *TEST FIXTURE	1		! !
1 2	-	READ VOLTAGE OVER A PERIOD OF 30 SECONDS.  ACTUAL VOLTS	! ! M	and the first state of	;
2	1	HIGH TENSION TRANSFORMER TEST: CHECK RESISTANCE BETWN THE 2 TERMINALS TO WHICH PRIMARY LEADS ARE ATTACHED.			
; ;	} }	ACTUAL OHM *OHMMETER	1	1 } !	1 } }
	1	ADJUST FOR GAP & INTERNAL PRESSURE.	! ! M		)   
}   	i	*IGNITION OUTPUT TESTER	1		;   
1 2	270 I	REPAIR OR REPLACE AS NECLSSARY.			[ [ [
2	1	TO CLINCH KNURLED FLANGE TO CASE, TORQUE A NUT AGAINST OUTER WALL OF CASE.  ACTUAL IN/LB	I !!		#
!	ļ	TORQUE WRENCH.	] 	! !	! !
3	1	ALL SCREWS & LOCKNUTS SHOULD BE TORQUED.  ACTUAL IN/LB *TORQUE WRENCH	1 1 M	) 	; ; ;
1 3		TEST IAW T.O. 8E1-8-7-3, PARA 2-36 SUB PARA "A"	! ! M		     
		*TEST FIXTURE	1	 	
	1	RAISE TRANSIFIER VOLTAGE REGULATOR UNTIL WAVE FORM DISPLAYED ON VOLTA-SCOPE SHOWS FIRST PEAK.	! ! M	•••••   	 
1	] 	ACTUAL VOLTS	i i	} }	1 1

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<b>9</b>	CAECOS	¥ WORK -16.FUN/		PAGE 5	OF 7	PAGESI
į	STATION	10P NO.		118.MECH		120"0"1
ز آ ا	;	350	· ·	İ		
1		360	REASSEMBLE.	1		
! ! !	 		TEST STORAGE CAPACITOR; RAISE INPUT I VOLTAGE TO 14V FOR NO MORE THAN 10 I SECONDS. VALUE	M 	•••••	
!	! !		I ACTUAL VOLT I *VOLTASCOPE	1 1	  - 	! ! ! !
1			I TEST: I INPUT VOLTAGE 14 I INPUT CURRENT I SPARK RATE			
 	;		I ACTUAL AMP ACTUAL SR	; ;		
i i	; ; ;		I INPUT VOLTAGE 24 I INPUT CURRENT I SPARK RATE	1 1 1 1		
! !	! !		AMP ACTUAL SR	1 1	 	
; ; ;	, , ,		I INPUT VOLTAGE 29 I INPUT CURRENT I SPARK RATE	*		; ; 
1	! !		I ACTUAL AMP ACTUAL SR	<b>!</b> !	•	
1 1	 	390	I TIGHTEN HEX NUTS AT INPUT END, LARGE NUT SHOULD BE TORQUED & THE 2 SMALL-			
i	; ;		ACTUAL AMP ACTUAL IN/LB I *TORQUE WRENCH	•		
1 1		400	SOLDER UNIT.	      M		
(	)	410	I TEST EXCITER FOR LEAKS USING A PROBE I WITH 14 PSIG. LEAKAGE.		<del></del>	
1			ACTUAL CC 1 *VEECO LEAK DETECTOR	<b>!</b>		1 1
1			I SUBMERGE EXCITER IN WATER HEATED TO I MINIMUM OF 49 DEG C (120 DEG F) FOR	i	***************************************	

15.DISP-	-16.PDN/	CONTROL DOCUMENT * JC 1.DATE 89045			
	IOP NO.		118.MECH	19"P"	[20"@
) :		I 1 AINUTE.			1
,	}   	I GAS CHARGING: BAKE EXCITER 15 MIN. I AT 275 DEG F. THEN TURN ON VACUUM I PUMP SWITCH & EXHAUST EXCITER WHILE I CONTINUING TO BAKE FOR ADDITIONAL I 15 MINUTES.	1 m		! !
W41	440	PAINT.	M		<del></del>   
!	450	BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F. OR AIR DRY.	]		·   
		I TEST: SET MICROMETER UNTIL SCALE READING INDICATES SPARK GAP OF 0.100 I INCH. ADJUST NITROGEN INLET UNTIL GAGE HOLDS STEADY.	]		
 		ACTUAL PSIG *IGNITION OUTPUT TESTER	1 1	1	!
! !		TEST: I INPUT VOLTAGE 14 I INPUT CURRENT I SPARK RATE	M		
, 1 1 1 1	; ; ;	ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE		; ; ; ;	
! ! !	 	ACTUAL AMP ACTUAL PER 10 SEC	! ! ! !	1	
1	1	INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE		! ! !	
 	1 1 1 1	ACTUAL AMP ACTUAL PER 10 SEC		1	
; ; ;	490 i	APPLY 24V INPUT CURRENT. UBTAIN ONE (1) OF THE FOLLOWING: METER READING	M		
	! !	72.5 78.0 83.0 87.5 91.5	1	1 1 1	
i	; ;	ACTUAL		; ;	

(

	IOP NO.	117.WORK TO BE ACCOMPLISHED	118.MECH	119"P"	120"0
1		I AFTO FORM 349 COMPLETED & FORWARDED I TO DATA AUTOMATION. I CERTIFY THAT THIS END ITEM HAS		i	<del></del>     
	! !	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	! M ! !		
!	<b>!</b> !	I TYPE WORK PERFORMED		,     	'     
		OPERATIONS COMPLETED & PAPERWORK   PROCESSED.	1 M	 	
; ;	i i i	1 1 1	} †	; ; ;	† † ‡
!		· ! !		] ! }	! !
 	 	? ! !	\	{ 	<b>!</b> ! !
! !		; ; ;	1	! !	[ ] ]
	 	! ! !	} † }	! ! !	! { ! !
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(	] 	 	1	i i	} <b>}</b>

		CUNTRUL DUCUMENT % JC 1.DATE 89033			
2.0RIO/	PROD NR	13.QUANTITY 14.PROD SECTION/RCC 15.DATE 1 MTPCAJ 1 89		· · · · ·	COMP
AVIIAI	134	19.ITEM SERIAL NR 18/12.TECH DATA 1 1 PO MAT87-3 	A/OFTIONA		4245H
J 57		I/SERIESIII.STOCK NR   CHG 1   4810002041575RV			
	I ELECTR	IZEND ITEM NOUN   NOMAG 3 WAY SELECT VLVPACT NOSZMATUACZ65920			
	TOP NO.		118.MF-CH		 เว <sub>็</sub> ง"ผ
W 43	1 010	,	l n		\$ · ·· · · · · · · · · · · · · · · · ·
	015	ALL REFERENCES ARE TO THE BASIC T.O.  1 & APPLICABLE PROCESS ORDERS. TECH  1 CATA CONTAINS DETAILED NOTES,  1 CAUTIONS, WARRINGS, DIMENSIONS &  1 TULERANCES REQUIRING COMPLIANCE.		1	; ····· ; ; ;
	920	DISASSEMBLE.	I M	1	;
)	। (/30 	I CLEAN AS REQUIRED.		1	} }
<b></b>	1 040 I 040	I INSPECT.	- 1	1	} } }
· · · · · · · · · · · · · · · · · · ·	( 04!)	I INSPECT SPRINGS FOR UPACKS USING I FED SPEC MIL-I 3038A.	i i i i	1	· · · · -   
	9:10	THISPECT SPRING (12)	i n		<del></del>
; ;		I ACT: INCH I HEIGHT I ACT: INCH	1	; ; ;	i } !
!	 	LOAD LACT: LBG		1	
; ;	 	FACT: INCHT	1	! !	{ } }
	) 	LES	-	† . †	 
	200-	TUDE OF STREET OF CO.	1 1 m	1	<del>!</del> !
1		T ACT: INCH. I WURKING I HEIGHT	    -	1 1	{ { {
י	 	I ACT: INCH	<b>}</b> !	1	•
: ! لد		L HEIGHT LEG	1 1	; ; !	i 1 1
		I ACT: 1NCH (CONTINUED)	•	ł	i

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	LSP-16.PDN/ CONTOP NO.		E ACCOMPLISHED		II8.MECH	119"12"	12 <b>0"</b> u"
		I LUAD	LBS				· · · · · · · · · · · · · · · · · · ·
<del>-                                   </del>	070	I MINUTE. I LEAKAGE ACT	UMAGNET COIL: JOLIS RMS, FOR MA N OF DIELECTRIC				
· · · · · · · · · · · · · · · · · · ·	1 080	I REPAIR OR RE	EPLACE AS NECES	SARY.	}		   
	1 090	1 ROUTE BODY F 1 3001, POST F	7N 1043256 10< 2-39 FOR MACHIN	MIPEN LIDE INII. MITOCH	1 11 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	: - · · · · · · · · · · · · · · · · · ·	1 ·· 1 1
<del></del>	100	REASSEMBLE.		7777	!		   
	110		ANCE FROM UITE ARMATURE TO BOD BURFACE		1 M		
		i PZN	ACT	18		, !	,   
	1 120	REGUIRED SPE	KING (5) WEIGHT	LES	1 1 11	;	• · · · · · · · · · · · · · · · · · ·
	1 1 50		IWEEN AKMATURE BODY UPPER LAN			# ··· ·- ·	· · · ·
			ACT #	INCH	1		} } · · · · · · · · · · · · · · ·
	1 140	I TURQUE SCREI	J (1) AUT:	TNZES	! ! M !	1 1	1 [
	150	L BODY SHOULDE	TANCE FROM LOWE ER TO BOTTOM OF OWER NEEDLE WIT	SPRING	!	j ! ! !	} · · · · · · · · · · · · · · · · · · ·
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<b>!</b>	i i	! ' <b>.</b>	ACT:			1	1	l l
		APPLY 50 FS16 TO PORTS. NO EXTEN ALLOWED.				   M 		     
		OPERATION TEST: TO PRESSURE PORT 1 VOLT DC TO SOL 1 SHALL FLOW THE A	T. APPLY ENUID. V APPLIED TE	18 +/- VALVE	-	)   I1   I		1
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	ORIG/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHED 16.DATE COM 98093A   MTFCAP   89094				
	NUMBER	19.ITEM SERIAL NR 18/12.TECH DATA 1	121	500	7074H
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15.0TSP STATION	-15.FDN/	يت ويد هم هم الله الله الله الله الله الله الل	118.MECH	19"F"	20"6"
W3	520	RECEIPE, IDENTIFY & ATTACH PAPERWORK	M	<del></del>	
	1	ALL REFERENCES ARE TO THE BASIC T.O. LAND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES.		<del></del>	
		CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.			
	625	DISASSEMBLE. C #48/11/2	i m		<del></del>
DENET	1025	REPAIR CASE ASSY. REQ. NOT REQ.	! M		<b></b>
	530	CLEAN AS REQUIRED.  I (DO NOT WIFE OR BRUSH AWAY THE EXCESS SOLDER & DO NOT DAMAGE SOLDER I COATING)	1 M		
	1 040 1	I INSPECT AS REQUIRED.	 	   	   
		CAPACITOR TEST: TEST SMALLER MULTI- I PLE CAPACITOR. GROUND "B" TERMINAL I TO CASE. APPLY 5000UDC BETWEEN TER- I MINALS C, D & E AND CASE FOR NOT I MORE THAN 30 SECONDS. I & ACTUAL C.	i — — — —   i M		
V	560	##EST CONSOLE D.    AFPLY 5000VDC BETWEEN TERMINALS "A"   & "B" FOR NOT MORE THAN 30 SECONDS.   ACT:	! ! !	 	 
	560	REMOVE GROUND FROM "B" TERMINAL. SHRT "B" TERMINAL TO "A" TERMINAL & APPLY 5000VDC BETWEEN TERMINALS "A" S "B" & THE CASE FOR NOT MORE THAN 30 SECONDS.	1 1	: 	<b>;</b> ; ;
		ACT: CHECK CAPACITANCE BETWEEN TERMINALS: A TO B ACT:	1	<b>)</b>	<b> </b>

		CONTROL DOCUMENT * 72-10 1.DATE 89045	PAGE 2	OF 6	PAGES
STATION	10P NO. 1	17.WORK TO BE ACCOMPLISHED	118.MECH	19"P"	20"Q
<u> </u>		E TO CASE ACT: *CAPACITOR BRIDGE TESTER	i i	· ·	
	0°-0'	TEST LARGER MULTIPLE CAPACITOR BY APPLYING 5000VDC BETWEEN TERMINALS "A" & "C" FOR NOT MORE THAN 30 SEC.	! M !	     	      
		ACTUAL  *TEST CONSOLE WHILE SHORTING TERMINALS "A" & "C" TOGETHER, APPLY 5000VDC BETWEEN TER- MINALS "8" & "C" FOR NOT MORE THAN 30 SECONDS. ACT: SHORT TERMINALS "A", "B" & "C" TOGE- THER & APPLY 5000VDC BETWEEN TERMIN- ALS & CASE. ACT: CHECK CAPACITANCE FROM TERMINAL "A" TO "C" & FROM TERMINALS "C" TO "B" ACT: A TO C ACT: C TO B			
J. 1 4	   160	*CAPACITOR BRIDGE TESTER  FILTER TEST: APPLY 400VDC BETWEEN LONGER OUTPUT TERMINAL & GROUND, WHILE "C" PIN IS GROUNDED. THERE MUST BE NO SIGN OF BREAKDOWN.	!		         
		*TEST CONSOLE APPLY 600VDC BETWEEN SHORTER OUTPUT TERMINAL & GROUND, WHILE TB" PIN IS GROUNDED. THERE MUST BE NO SIGN OF BREAKDOWN. CHECK LEAKAGE BETWEEN SHORTER OUTPUT TERMINAL & GROUND, WHILE "B" PIN IS GROUNDED: THEN CHECK LEAKAGE BETWEEN LONGER OUTPUT TERMINAL & GROUND WHILE "C" PIN IS GROUNDED.	i i		 
		ACT: WARCUMTUBE VOLTMETER REAGURE CAPACITANCE BETWEEN SHORTER GOTPUT TERMINAL & GROUND ACT: *CAPACITOR BRIDGE TESTER BETWEEN LONGER FILTER OUTPUT TERMINAL & GROUND ACT:			; ; ; ; ; ; ;
	   210	RESISTOR TEST: RESISTORS (6)	     M	<b></b>   	   
30		(6) ACTUAL *VACUUM TUBE VOLTMETER 3.95-	1	-	! !
		RESISTOR (5)	 	   	-÷   

#   -CAEC11   15.DISP-		**************************************			
		17.WORK TO BE ACCOMPLISHED	118.MECH	19"P"	20"Q"
		RESISTOR (10)	) 	 	! !
         	1	I AC RECT. TEST: I ADJUST VOLTAGE TO 4000V & READ IN- I VERSE VOLTAGE CURRENT ON SAME METER I BY PUSHING BUTTON MARKED "500UA".	6 m		
; ; ; ; ;	; ; ;	ACTUAL  *VOLTAGE REGULATOR  RAISE VOLTAGE UNTIL MILLIAMETER  SHOWS A READING OF 190MA. READ  VOLTAGE DROP ACROSS RECTIFIER  ACT			
		TUBE F/N 85944 I DISCHARGER TUBE TEST: ALLOW DIS- I CHARGER TUBE TO FIRE FOR 4 MINUTES, I THEN DURING SUCCEEDING 1 MINUTE I PERIOD OBSERVE BREAKDOWN VOLTAGE. I .	1 1 m 1 1		
	 	ACTUAL	} ! !	<b>!</b>	
-		TUBE P/N 24222:   ADJUST HIGH VOLTAGE REGULATOR UNTIL   TUBE IS FIRING AT A RATE OF 1 SPARK   PER SECOND; THEN DURING THE SUCCEED-   ING 30 SECOND PERIOD OBSERVE THE   BREAKDOWN VOLTAGE.	   M     		
		ACTUAL	j		) 
	310 090	TUBE P/N 24498: VALUE OF BREAKDOWN VOLTAGE OF TUBE UNDER TEST OVER A PERIOD OF 1 MINUTE	! ! M !		
 	! }	ACTUAL ACTUAL	<b>\$</b> <b>\$</b>	<b>!</b> [	! !
	320	FEED-THRU TERMINAL TEST: APPLY 5000V DC BETWEEN TERMINAL & CASE, LEAKAGE ACTUAL		 	   
		HIGH TENSION TRANSFORMER TEST: SET UP IGNITION OUTPUT TESTER & ADJUST FOR GAP OF 0.200 IN & INTERNAL PRESSURE OF 20 PSIG.		;	<b></b>        
		. 00 3>53	 	 	     

		######################################	PAGE 4	OF 6	PAGES
ISTATION			18.MECH	19"P"	20"0"
0	ļ	SMALL TRANSF TEST:   CHECK CONTINUITY BETWEEN "C" & "A"   LEADS AND BETWEEN "C" & "B" LEADS.	i M	G.MIA	<b>L</b>
	380	POWER TRANSF TEST: APPLY 80V, 400 CYCLE AC, BETWEEN PRIMARY TERMINAL & GROUND, READ EXCITING CURRENT	i M i M		 
:		ACTUAL SHORT SECONDARY TERMINALS TOGETHER & APPLY 2000 VDC BETWEEN PRIMARY & SECONDARY TERMINALS FOR 30 SECONDS. THERE MUST BE NO EVIDENCE OF ELECTRICAL BREAKDOWN.		 	
	120	IAW CHOPPER TEST (PER T.O. PG 4-17)	! ! M		: :
	380	REPAIR OR REPLACE AS NECESSARY.	М		 
	:	HIGH TENSION TRANSF RAISE PRESSURE TO 25PSIG & RUBMERGE UNIT IN WATER. LEAK CHECK FOR BUBBLES. SOURCE 13 INCH	1 M 1 Z 19		
<u></u>	) i	REMOVE ADAPTER & BAKE ASSY IN OVEN	64	Z 14	RFLO
	370	REASSEMBLE.	M	 	,   
	390	LAY A NEW GROUNDING BRAID (14) IN GROOVE IN CAP (13), MAKING CERTAIN IT LIES DEEP IN GROOVE TO PREVENT FRAYING OR PINCHING WHEN CAP IS SCREWED ON. TORQUE CAP ACTUAL WRENCH	, M		
	460	RMEDIATE TEST:  CAGE CAPACITOR: TEST HIGH VOLTAGE  LAD ON "A" TERMINAL OF LARGER MULT-  IPLE CAPACITOR, RAISE INPUT VOLTAGE  TO 14V FOR NOT MORE THAN 10 SECONDS.	1		
C	 	ACTUAL  *TEST CONSOLE  APPLY INPUT VOLTAGE SUCCESSIVELY AT  14,24, & 29 V. AT A RATE OF NOT LESS  THAN 5.0 SPARKS OVER A 10-SEC PERIOD  & READ INPUT CURRENT ON TEST CONSOLE  (14) ACT S/R ACT AMPS	)   		! !! ! !! ! !!
	l (	(24) ACT S/R ACT AMPS (29) ACT S/R ACT AMPS READ STORAGE CAPACITOR VOLTAGE ON (CONTINUED)	)   		

113.013.	TO SE DIME	CONTROL DOCUMENT * 72-10 1.DATE 89045 17.WORK TO BE ACCOMPLISHED			
	1	17.WORK TO BE NOCOMESTABLE	i		20   <mark>-</mark> -
	i ; i ;	VOLTASCOPE ACT: VOLTS READ INPUT CURFENT & SPARE RATE IN WINDOW OF OUTPUT TESTER CONNECTED TO LEFT OUTPUT.	! ! ! !		; ; ; ;
		ACT: AMPS ACT: S/R			 ! – –
; } !	520	PREPARE UNIT FOR FILLING WITH POT- TING COMPOUND BY PRE-BAKING FOR AT LEAST 1 HR AT 300 DEG F.	; ; M	 	
		PARE EXCITER IN CIRCULATING AIR OVEN AT LEAST 2 HRS AT TEMP OF 220 DEG F. RAISE TEMP TO 300 DEG F CURE 4 HRS.			! !
	525	SOLDER 3 TORQUE FILTER ATTACHING JAM NUT ACTUAL (N/LBS *TORQUE WRENCH	 		         
	1 , , 1	WHILE APPLYING HEAT TO FLOW SOLDER. TORQUE SLOWLY. FILL SLOTS IN SCREW HEADS WITH SOLDER			
		4-32 ACT 8-32 ACT +TORQUE WRENCH		 	 
 	1	PRESSURE TEST: TEST FOR LEAKS USING PROBE WITH 15 FOIG IN EXCITER WITH HELIUM. (ALT LEAK CHECK IN WATER)	; ; M !	 	
 		ACTUAL *VEECO LEAK DETECTOR	1	i	!
	500 540	GAS CHARGING: SET THERMOSTAT AT 290 DEG F; BAKE EXCITER 15 MIN AT THIS TEMP. TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO EXHE FOR AN ADDITIONAL 15 MINUTE.	M		
	160	#GAS CHARGING FIXTURE		) [	) 
₩-41	590 I	MOVE EXCITER TO PAINT SHOP.	i i m	   	     
	560	PAINT BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F.	M		     
	d10	FINAL TEST RAISE INPUT VOLTAGE TO 24V. RAD INPUT CURRENT & METER READING	M		,     
,   y .	1510	ON TESTER  CONTINUED)	; !	• •	i I

,	CAEC11		CONTROL DOCUMENT * 72-10 1.DATE 89045	PAGE 6	OF 6	PAGES
				18.MECH	19"F"	20"Q"
			ACT: ACT  **TEST CONSOLE  PUSH "COUNTER RESET" BUTTON & READ  RATE ON COUNTER.  ACT: S/R  RAISE INPUT VOLTAGE TO 115V AT 400  CYCLES. READ INPUT CURRENT & METER  READING ON TESTER  ACT: ACT:  RAISE VOLTAGE 115V AT 400 CYCLES & PUSH "COUNTER RESET" BUTTON TO READ			
		670 NE	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	     M	   	
		650	SAFETY WIRE	! <b>M</b>	i I	, , ,
		660	I CERTIFY THAT THIS END ITEM HAS I REEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS AND SUPPLEMENTS	i M		
ļ			OPERATIONS COMPLETED AND PAPERWORK PROCESSED	     M		 
·•		680	COMPLY WITH MADI 66-36, PARA 13 TYPE WORK PERFORMED	      M	     	
·				 	 	 